MODEL G4030
6 ½" x 10" METAL-CUTTING BANDSAW

OWNER'S MANUAL

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⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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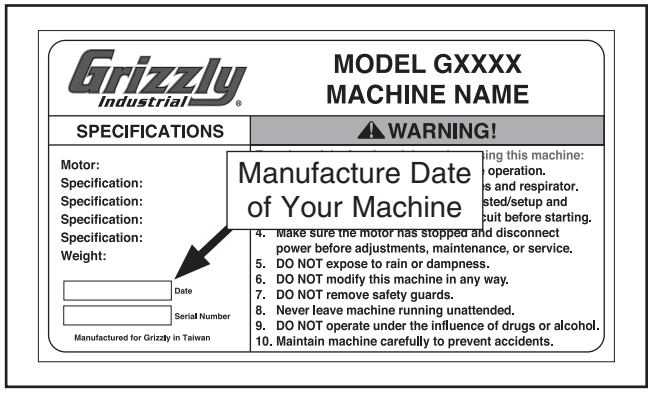
INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.



For your convenience, we post all available manuals and manual updates for free on our website at **www.grizzly.com**. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
E-Mail: techsupport@grizzly.com

We want your feedback on this manual. If you can take the time, please email or write to us at the address below and tell us how we did:

Grizzly Industrial, Inc.
C/O Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G4030 6-1/2" X 9 1/2" METAL-CUTTING BANDSAW

Product Dimensions:

Weight	270 lbs.
Length/Width/Height	42 x 15 x 59-1/2 in.
Foot Print (Length/Width)	34 x 12 in.

Shipping Dimensions:

Type	Wood Slat Crate
Content	Machine
Weight	289 lbs.
Length/Width/Height	19 x 45 x 43 in.

Electrical:

Switch	Automatic Shut Off
Switch Voltage	110V
Cord Length	5-1/2 ft.
Cord Gauge	16 gauge
Plug Included	Yes

Motors:

Main

Type	TEFC Capacitor Start Induction
Horsepower	3/4 HP
Voltage	110/220V
Prewired	110V
Phase	Single
Amps	12.5/6.25A
Speed	1725 RPM
Cycle	60 Hz
Number Of Speeds	1
Power Transfer	Gear
Bearings	Shielded and Lubricated for Life

Main Specifications:

Operation Info

Blade Speeds	100, 180, 235 FPM
Std. Blade Len	85 in.

Cutting Capacities

Angle Cuts	45 - 90 deg.
Vise Jaw Depth	9-1/2 in.
Vise Jaw Height	3-1/2 in.
Max. Capacity Rect. Height At 90D	6-1/2 in.
Max. Capacity Rect. Width At 90D	10 in.
Max. Capacity Rnd. At 90D	6-1/2 in.
Max. Capacity Rect. Height At 45D	6 in.
Max. Capacity Rect. Height At 30D	6 in.
Max. Capacity Rect. Width At 30D	5-1/8 in.
Max. Capacity Rnd. At 30D	5-1/8 in.
Max. Capacity Rect. Width At 45D	2-1/8 in.
Max. Capacity Rnd. At 45D	2-1/8 in.

Construction

Table Construction	Precision Ground Cast Iron
Wheel Construction Upper	Cast Iron
Wheel Construction Lower	Cast Iron
Body Construction	Cast Iron
Base Construction	Pre-formed Steel
Wheel Cover Construction	Pre-formed Steel
Paint	Epoxy

Other

Wheel Size	10-3/4 in.
Blade Guides Upper	Ball Bearing
Blade Guides Lower	Ball Bearing
Coolant Cap	3.4 GAL

Table Info

Table Size Length	15-1/2 in.
Table Size Width	8 in.
Floor To Cutting Area Height	21 in.

Other Specifications:

Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	ID Label on Body Frame
Assembly Time	45 minutes

Features:

Built-in Coolant System
Hydraulic Feed
Includes Blade, Blade Chip Brush, Safety Guards and Vertical Saw Table
Separate Coolant Switch
Heavy Cast Iron Machine Table
Rapid Approach Vise
Roller Cabinet
Adjustable Blade Guides and Rollers
Automatic Shut off
Three Cutting Speeds
Band Tension Adjustment
Hardened and Ground Worm Gears

Identification

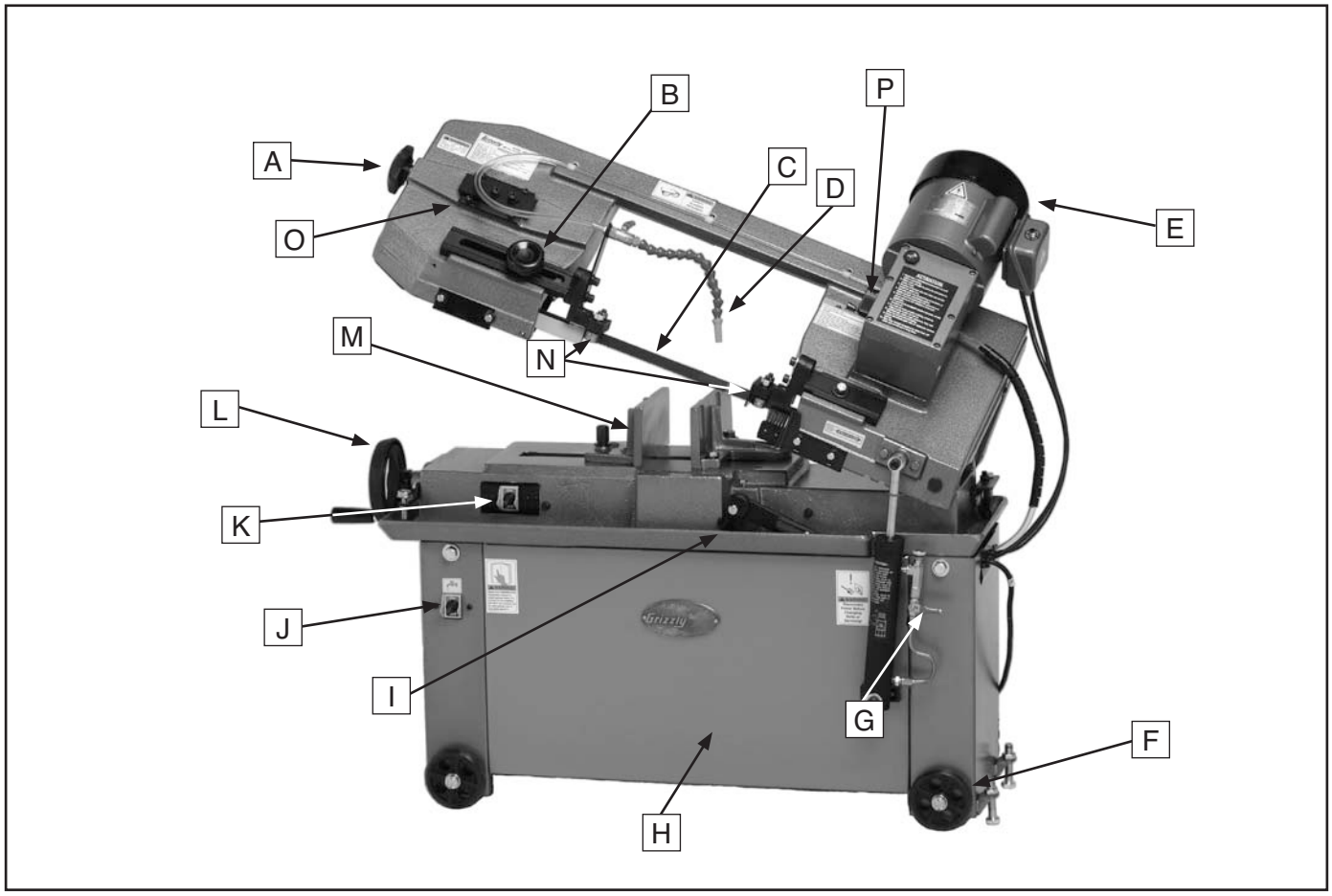


Figure 1. Main view of machine features.

A. Blade Tension Knob
B. Guide Post Adjustment Knob
C. Blade
D. Coolant Nozzle
E. ¾ HP Motor
F. Wheels
G. Feed Rate ON/OFF Valve
H. Bandsaw Cabinet
I. Workstop
J. ON/OFF Switch for Coolant Nozzle
K. ON/OFF Switch
L. Vise Handwheel
M. Vise
N. Blade Guides
O. Blade Tracking Controls
P. Gear Shift Lever

SECTION 1: SAFETY

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

⚠WARNING

Safety Instructions for Machinery

OWNER'S MANUAL. Read and understand this owner's manual BEFORE using machine. Untrained users can be seriously hurt.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery. to reduce the risk of eye injury or blindness from flying particles Everyday eyeglasses are not approved safety glasses.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

WEARING PROPER APPAREL. Do not wear clothing, apparel, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips which could cause a loss of workpiece control.

HEARING PROTECTION. Always wear hearing protection when operating or observiing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

MENTAL ALERTNESS. Be mentally alert when running machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

⚠WARNING
Safety Instructions for Machinery

DISCONNECTING POWER SUPPLY. Always disconnect machine from power supply before servicing, adjusting, or changing cutting tools (bits, blades, cutters, etc.). Make sure switch is in OFF position before reconnecting to avoid an unexpected or unintentional start.

INTENDED USE. Only use the machine for its intended purpose and only use recommended accessories. Never stand on machine, modify it for an alternative use, or outfit it with non-approved accessories.

STABLE MACHINE. Unexpected movement during operations greatly increases the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

GUARDS & COVERS. Guards and covers can protect you from accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly before using machine.

REMOVING TOOLS. Never leave adjustment tools, chuck keys, wrenches, etc. in or on machine—especially near moving parts. Verify removal before starting!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

DANGEROUS ENVIRONMENTS. Do not use machinery in wet locations, cluttered areas, around flammables, or in poorly-lit areas. Keep work area clean, dry, and well lighted to minimize risk of injury.

APPROVED OPERATION. Untrained operators can be seriously hurt by machinery. Only allow trained or properly supervised people to use machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

CHILDREN & BYSTANDERS. Keep children and bystanders a safe distance away from work area. Stop using machine if children or bystanders become a distraction.

FEED DIRECTION. Unless otherwise noted, feed work against the rotation of blades or cutters. Feeding in the same direction of rotation may pull your hand into the cut.

SECURING WORKPIECE. When required, use clamps or vises to secure workpiece. A secured workpiece protects hands and frees both of them to operate the machine.

UNATTENDED OPERATION. Never leave machine running while unattended. Turn machine ***OFF*** and ensure all moving parts completely stop before walking away.

MAINTENANCE & INSPECTION. A machine that is not properly maintained may operate unpredictably. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. Regularly inspect machine for loose bolts, alignment of critical parts, binding, or any other conditions that may affect safe operation. Always repair or replace damaged or misadjusted parts before operating machine.

EXPERIENCING DIFFICULTIES. If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.

⚠WARNING

Safety Instructions for Metal-Cutting Bandsaws

1. **BLADE CONDITION.** Do not operate with dull, cracked or badly worn blade. Dull blades require more effort to use and are difficult to control. Inspect blades for cracks and missing teeth before each use.

2. **HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Serious personal injury could occur.

3. **GUARDS.** Do not operate this bandsaw without blade guard in place.

4. **BLADE REPLACEMENT.** When replacing blades, make sure teeth face toward the workpiece. Make sure the blade is properly tensioned after installing.

5. **WORKPIECE HANDLING.** Always support the workpiece with table, vise, or some type of support fixture. Flag long pieces to avoid a tripping hazard.

6. **BLADE SPEED.** Blade should be running at full speed and the feed rate set before beginning a cut.

7. **FEED RATE.** Always determine feed rate before the cut is started. Do not increase feed rate while cutting, especially when sawing small diameter tubes and rods.

8. **MATERIAL.** This machine is designed to cut metal only. Not all metals react the same when cutting. Know the material you are working with before cutting.

9. **CUTTING FLUID SAFETY.** For saws designed to use cutting fluid, always follow manufacturer's cutting-fluid safety instructions on use, storage, maintenance, and disposal.

10. **LEAVING WORK AREA.** Never leave a machine running and unattended. Allow the bandsaw to come to a complete stop before you leave it unattended.

11. **MAINTENANCE/SERVICES.** All inspections, adjustments, and maintenance are to be done with the machine ***OFF*** and disconnected from the power source. Wait for all moving parts to come to a complete stop.

12. **HABITS – GOOD AND BAD – ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.

13. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.

⚠WARNING

Like all machines there is danger associated with the Model G4030. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by a qualified electrician in accordance with all applicable codes and standards.

⚠WARNING

Electrocution, fire, or equipment damage may occur if machine is not correctly grounded and connected to the power supply.

Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 220V .. 6.25 Amps
Full-Load Current Rating at 110V ... 12.5 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements in the following section.

Circuit Information

A power supply circuit includes all electrical equipment between the main breaker box or fuse panel in your building and the incoming power connections at the machine. This circuit must be sized to safely handle the full-load current drawn from the machine for an extended period of time.

⚠CAUTION

For your own safety and protection of property, consult a qualified electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the circuit is properly sized for safe operation.*

Circuit Requirements for 110V

This machine is prewired to operate on a 110V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 110V/120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Circuit Rating ..... 15 Amps
Plug/Receptacle ..... NEMA 5-15

Circuit Requirements for 220V

This machine can be converted to operate on a 220V power supply. To do this, follow the **Voltage Conversion** instructions later in this section. The intended 220V circuit must have a verified ground and meet the requirements that follow:

Nominal Voltage 220V/240V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Circuit Rating ..... 15 Amps
Plug/Receptacle ..... NEMA 6-15

Grounding Requirements

In the event of certain types of malfunctions or breakdowns, grounding provides a path of least resistance for electric current—in order to reduce the risk of electric shock.

For 110V operation: This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (similar to the figure below). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

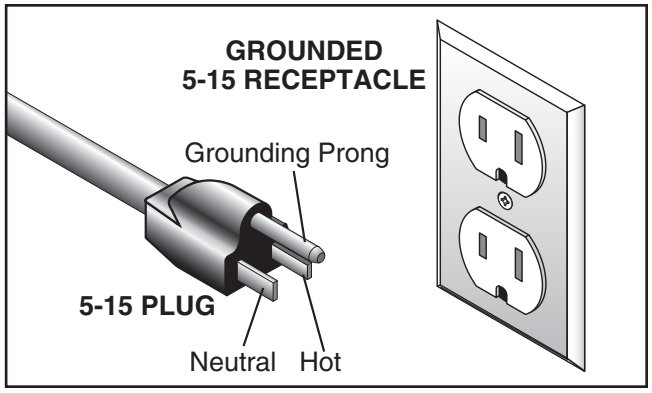


Figure 2. Typical 5-15 plug and receptacle.

For 220V operation: The plug specified under "Circuit Requirements for 220V" on the previous page has a grounding prong that must be attached to the equipment-grounding wire inside the included power cord. The plug must only be inserted into a matching receptacle (see below) that is properly installed and grounded in accordance with all local codes and ordinances.

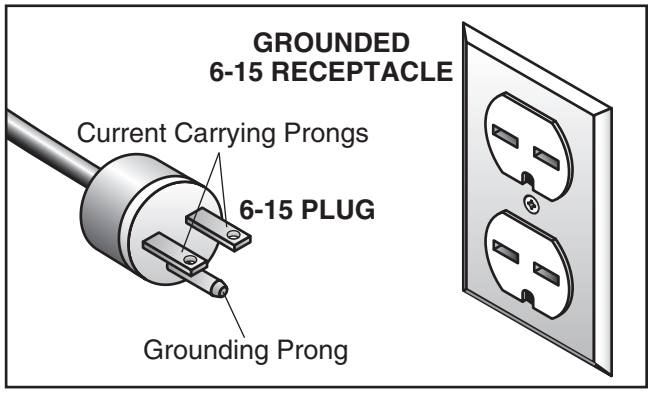


Figure 3. Typical 6-15 plug and receptacle.

⚠WARNING

Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

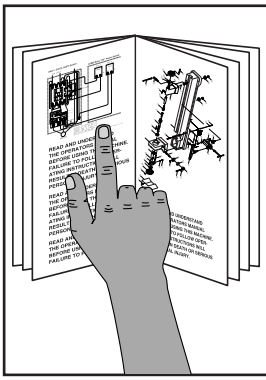
Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

Minimum Gauge Size .....12 AWG
Maximum Length (Shorter is Better).....50 ft.

SECTION 3: SET UP

Set Up Safety



⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

⚠WARNING

Wear safety glasses during the entire set up process!

⚠WARNING

The Model G4030 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

Items Needed for Set Up

The following items are needed to complete the set up process, but are not included with your machine:

Description	Qty
• Wrench 10mm	1
• Safety Glasses (for each person)	1
• An Assistant	1
• Phillips Head Screwdriver #2	1

Unpacking

The Model G4030 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advise.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.

Inventory

After all the parts have been removed from the box, you should have the following items:

Box Contents (Figure 4)	Qty
A. Drip Pan	1
B. Chip tray	1
C. Table	1

Items not shown:
Metal-Cutting Bandsaw 1

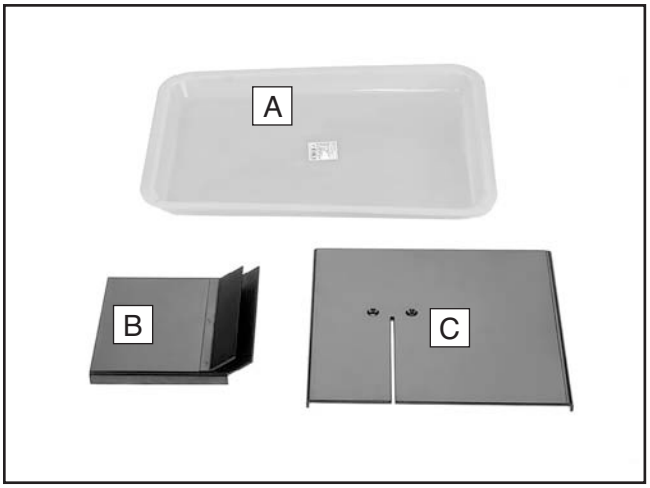
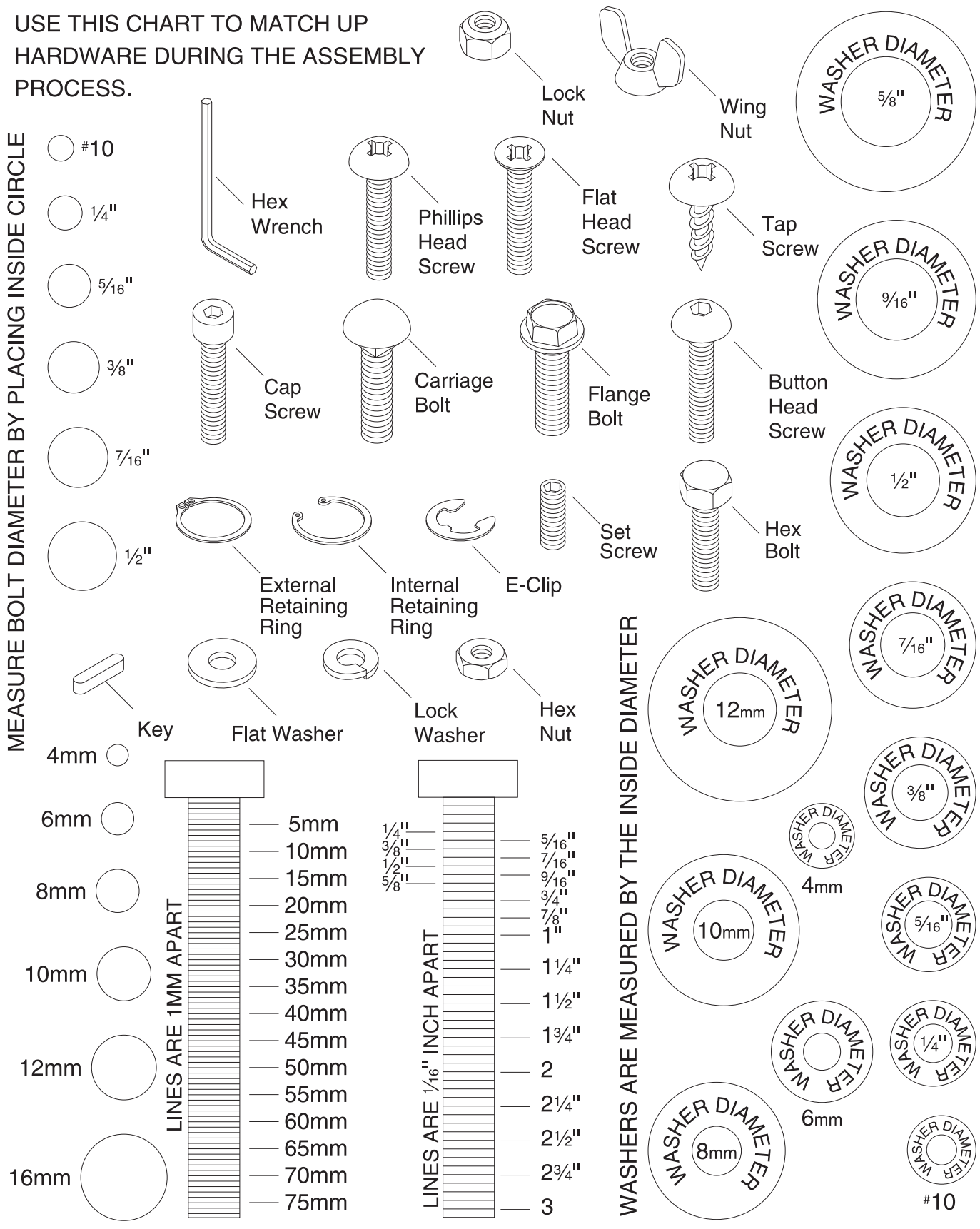


Figure 4. Loose parts inventory.

Hardware Recognition Chart

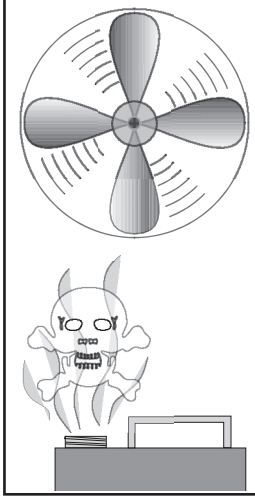


Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner, as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

⚠WARNING

Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.



⚠CAUTION

Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.

Site Considerations

Floor Load

The weight and footprint size for your machine is located in the machine data sheet. Most floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 5** for the minimum working clearances.

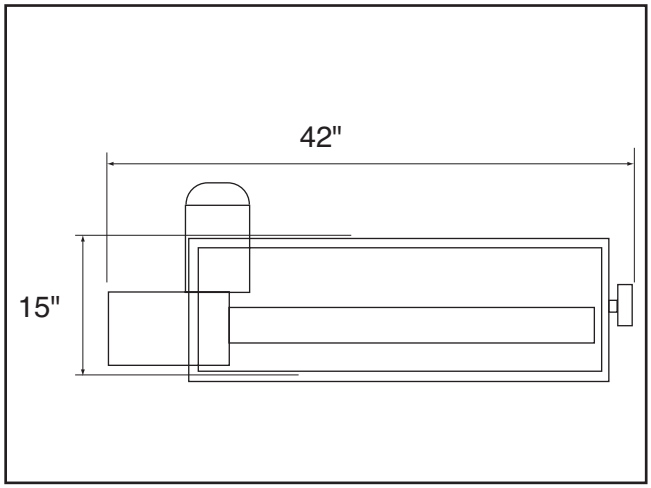
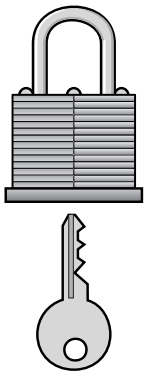


Figure 5. Minimum G4030 working clearances.



⚠CAUTION

Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!

Brackets

The shipping bracket keeps the saw from damage during shipment and must be removed. The switch control bracket is adjusted to shut the ON/OFF switch when the saw returns to the horizontal position.

To remove or adjust brackets:

1. Use a 10mm wrench to remove the shipping bracket shown in **Figure 6**.

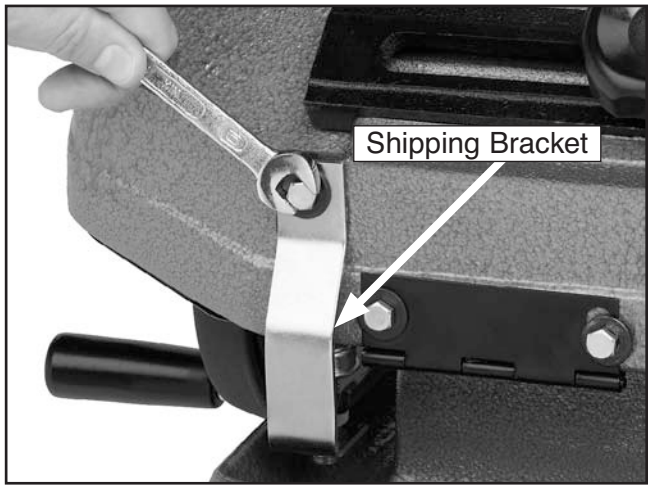


Figure 6. Removing shipping bracket.

2. Loosen the hex nut holding the switch control bracket with a 10mm wrench (**Figure 7**). Rotate the bracket so it is positioned over the switch in such a way so when the switch control bracket makes contact with the switch, it will push the switch down and ***OFF***.

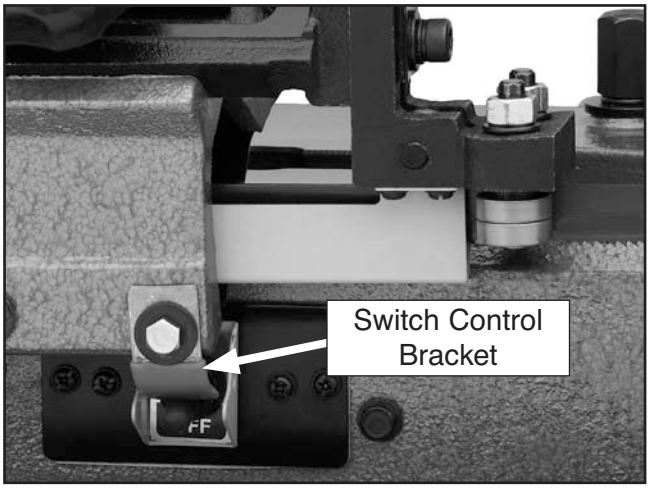


Figure 7. Safety switch bracket.

Vertical Assembly

The Model G4030 can easily be set up for vertical cutting operations.

Components and Hardware Needed: **Qty**
Table.....1

To assemble the bandsaw for vertical cutting:

1. If a piece of wood is clamped in the vise for shipping purposes, rotate the handwheel and remove the wood.

2. Lift the saw to the vertical position. Rotate the feed ON/OFF valve to the OFF position, as shown in **Figure 8.**

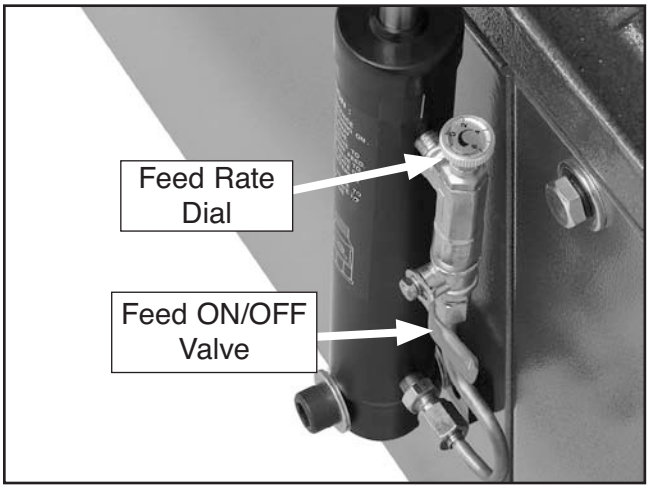


Figure 8. Feed ON/OFF valve and feed rate dial.

3. Remove the blade guide cover as shown in **Figure 9.**

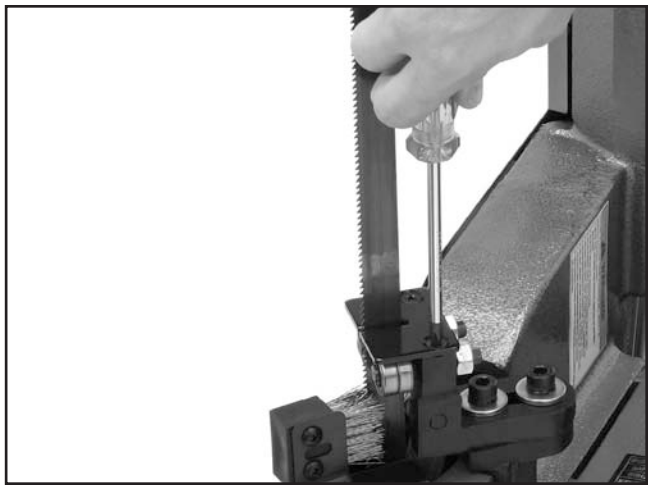


Figure 9. Removing blade guide cover.

4. Install the table (**Figure 10**) with the two screws removed in **Step 3.**

Figure 10. Table installed.

Chip Tray & Drip Pan

The chip tray and drip pan are designed to catch chips, coolant over-spray, and cut-offs during operation.

Components and Hardware Needed:	**Qty**
Chip Tray	1
Drip Pan	1

To install the chip tray:

1. Position the chip tray brackets over the coolant basin lip as shown in **Figure 11.**

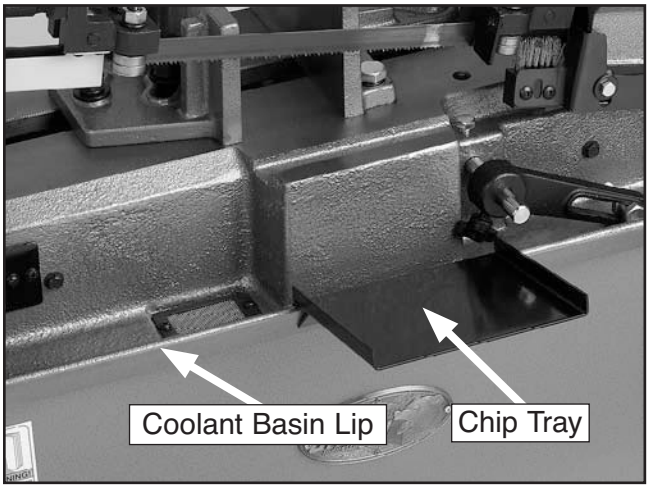


Figure 11. Chip tray installed.

To install the drip pan:

1. Slide the drip pan between the brackets as shown in **Figure 12** and make sure the hole in the pan is positioned directly above the coolant tank filter.

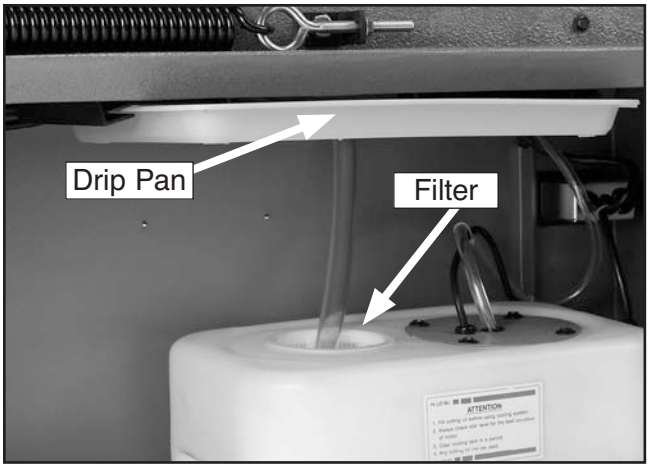


Figure 12. Drip pan installed.

Test Run

⚠WARNING

Projectiles thrown from the machine could cause serious eye injury. Wear safety glasses during assembly and operation.

NOTICE

DO NOT operate saw without checking gear box oil level! Operating without sufficient oil will damage the machine.

Starting the machine:

1. Read the entire instruction manual.

2. Check the gear box oil level to ensure it has oil.

3. Make sure all tools and foreign objects have been removed from the machine.

4. Put on safety glasses and secure loose clothing or long hair.

5. Raise the bandsaw and close the feed ON/OFF valve to keep the saw in place.

6. Start the bandsaw while keeping your finger near the ON/OFF switch at all times during the test run. The bandsaw should run smoothly with little or no vibration.

—If you suspect any problems, immediately stop the bandsaw, refer to the **Troubleshooting** section, and correct before continuing.

—If you need any help with your bandsaw call our Tech Support at (570) 546-9663.

Recommended Adjustments

The adjustments listed below have been performed at the factory. However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the adjustments remain unchanged.

Step-by-step instructions on verifying these adjustments can be found in **SECTION 7: SERVICE.**

Factory adjustments that should be verified:

1. Blade Tracking (**Page 30**).

2. Squaring the Blade (**Page 31**).

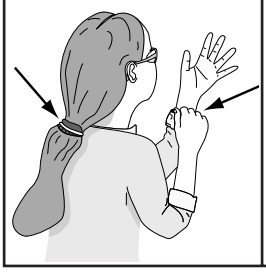
3. Blade Guide Bearings (**Page 32**).

SECTION 4: OPERATIONS

Operation Safety

⚠WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Vise

The vise can hold material up to ten inches wide and be set to cut angles up to 45 degrees.

To adjust the angle on the vise:

1. Loosen the lock nut with a 12mm hex wrench or socket as shown in **Figure 13**.

2. Use the scale as a guide to set your angle or use a machinist square to square the blade to the vise as shown in **Figure 14**.

3. Tighten the lock nut.

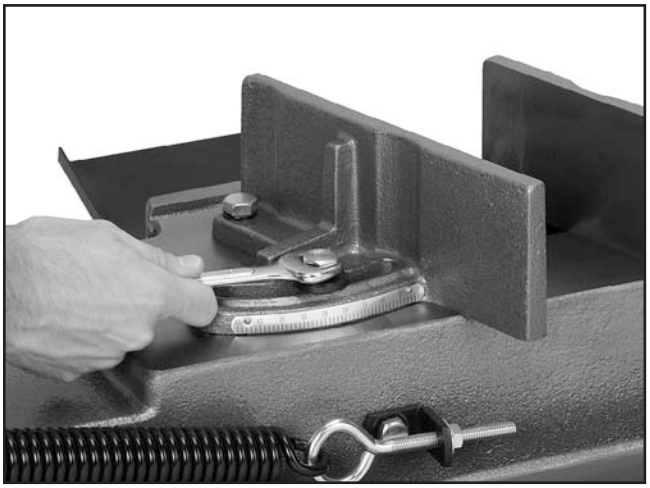


Figure 13. Setting vise angle.

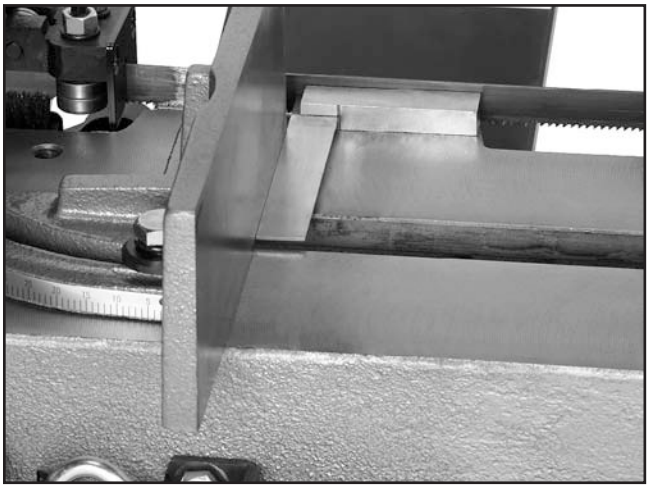


Figure 14. Squaring vise to blade.

4. Loosen the lock nut in **Figure 15** on the opposite jaw so the jaw can float, and match the angle of the workpiece.

5. Tighten the vise against the workpiece.

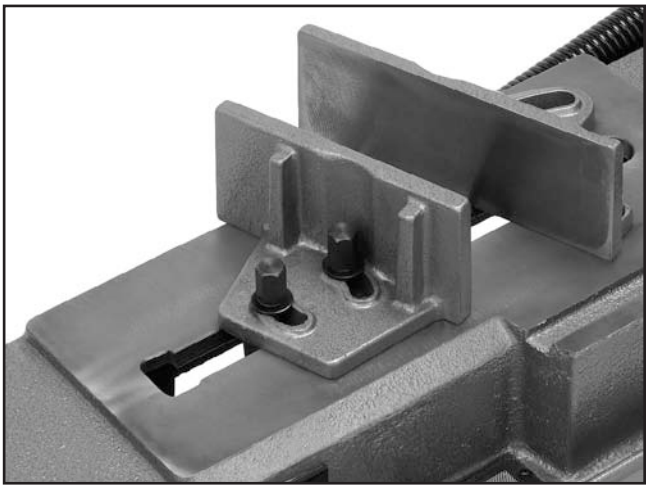


Figure 15. Vise jaw lock-nut.

Blade Speed

The Model G4030 has these three blade speeds: 100, 180, and 235 FPM.

NOTICE

DO NOT change speeds when the motor is running. Wait for the bandsaw to come to a complete stop or you will damage the gears.

To change blade speeds:

1. **Turn the bandsaw *OFF* and allow it to come to a complete stop.**

2. Determine the best speed for your cut. The table in **Figure 16** is provided as a rough guideline. Material thickness, type of blade used and if cutting fluid is used, will factor into the correct speed selection.

Material	Feet Per Minute (FPM)
Tool, Stainless, & Alloy Steels, Cast Iron	100
Medium to High Carbon Steels, Iron, Hard Brass or Bronze	180
Aluminum and Plastics	235

Figure 16. Blade speed table.

3. Pull up on the spring loaded lever and move the lever into your chosen speed. (see **Figures 17 & 18**).

Figure 17. Gear change lever.

●	●	●
A	B	C
235	100	180

Figure 18. G4030 Gear positions.

Blade Selection

The Model G4030 uses 85" x ¾" bandsaw blades.

Selecting the right blade for the job depends on a variety of factors, such as the type of material being cut, hardness of the material, machine capability, and operator technique.

We suggest you do some research for your specific situation so you get the best blade to match your needs.

Grizzly is proud to offer a variety of selections that can be found in the current catalog and in **SECTION 5: ACCESSORIES** on **Page 24**.

Cutting Fluid System

This bandsaw has a built-in cutting fluid system that extends the life of your bandsaw blades by lowering the temperature of the blade and workpiece, and washing away chips.

See **Cutting Fluid** on **Page 21** for more information.

To use the cutting fluid system:

1. Thoroughly clean and remove any foreign material that may have fallen inside the reservoir during shipping.

2. Place the filter screen and drain tube as shown in **Figure 19** in the reservoir.

⚠WARNING

FIRE HAZARD! DO NOT cut magnesium when using oil-water solutions as a cutting fluid! Always use a cutting fluid intended for magnesium. The water in the solution will cause a magnesium-chip fire.

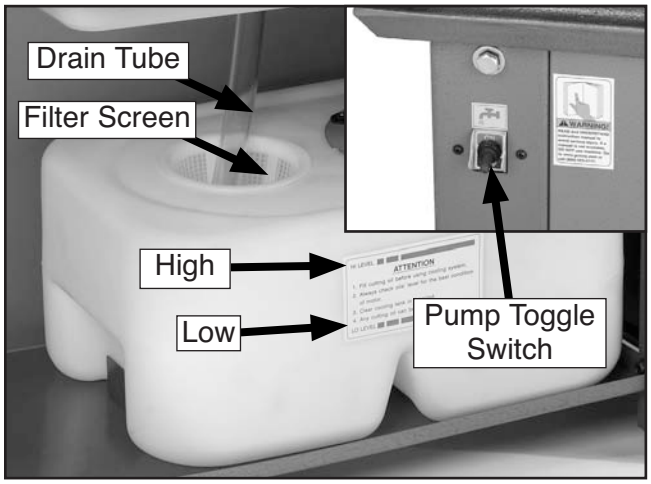


Figure 19. Filter screen and hose.

3. Fill the reservoir ¾ full with cutting fluid.

4. Position the fluid nozzle over the cut so the blade will be cooled and rinsed of chips. A chip tray is provided to catch over-spray and small parts (see **Figure 20**).

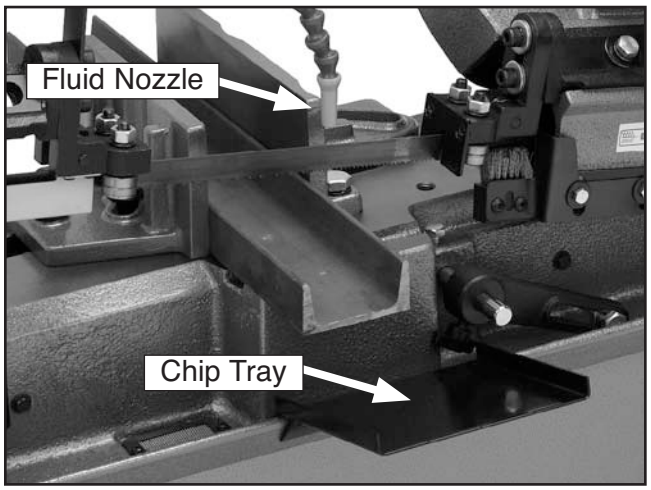


Figure 20. Fluid nozzle and chip tray.

5. Adjust the valve on the coolant hose to control the flow of coolant. Make sure that the pressure is not so high that coolant spills on the floor and creates a slipping hazard.

6. Turn the pump toggle switch ***ON*** before making your cut.

NOTICE: NEVER operate the pump with the reservoir below the low mark or you will over-heat the pump!

Cutting Fluid

While simple in concept and function, many issues must be taken into account and to find and use the correct cutting fluid. Always follow all product warnings and contact the fluid manufacturer for unanswered questions.

Use the selections below to choose the appropriate cutting fluids:

- For cutting low alloy, low carbon, and general-purpose category metals with a bi-metal blade—use a water soluble cutting fluid.
- For cutting stainless steels, high carbon, and high alloy metals, brass, copper and mild steels—use "Neat Cutting Oil" (commonly undiluted mineral oils) that have extreme pressure additives (EP additives).
- For cutting cast iron, cutting fluid is not recommended.

Remember: Too much flow at the cutting fluid nozzle will make a mess and can make the work area unsafe; and not enough fluid at the cut will heat the blade, causing the blade teeth to load up and break.

⚠WARNING

BIOLOGICAL AND POISON HAZARD! Use proper personal protection equipment when handling cutting fluid and follow federal, state, and fluid manufacturer requirements to properly dispose of cutting fluid.

Blade Guides

The blade guides should be as close to the workpiece as possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off the cut line.

To adjust the blade guides:

1. Loosen the knob shown in **Figure 21** and slide the rear blade guide as close to the workpiece as possible, then tighten the knob.

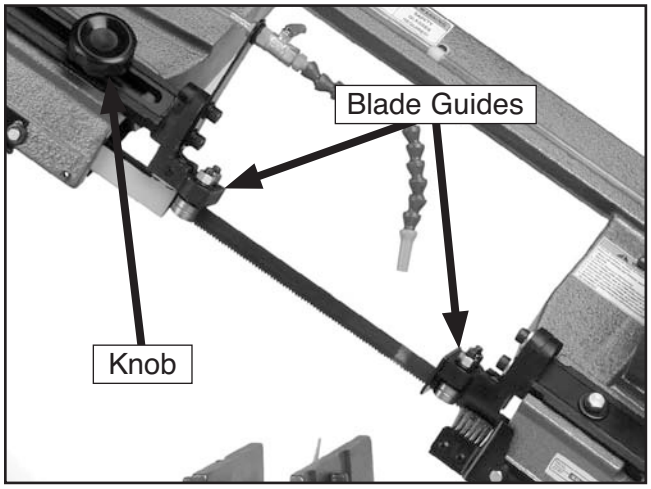


Figure 21. Blade guides.

Feed Rate

The speed at which the saw blade will cut through a workpiece is controlled by blade type, feed rate, and feed pressure.

Note: *If a lubricant is used on the cut, the feed rate can be increased by approximately 15%*.

To set the feed rate:

1. Raise the headstock to the vertical position.

2. Using a 14mm wrench, adjust the feed pressure tension spring. Tighten enough to remove play but not enough to apply tension to the spring (see **Figure 22**).

   Note: *This spring adjustment is an initial setting. Depending on cutting circumstances, you will have to fine-tune the feed pressure with this adjustment. Increasing the spring tension will reduce the feed pressure.*

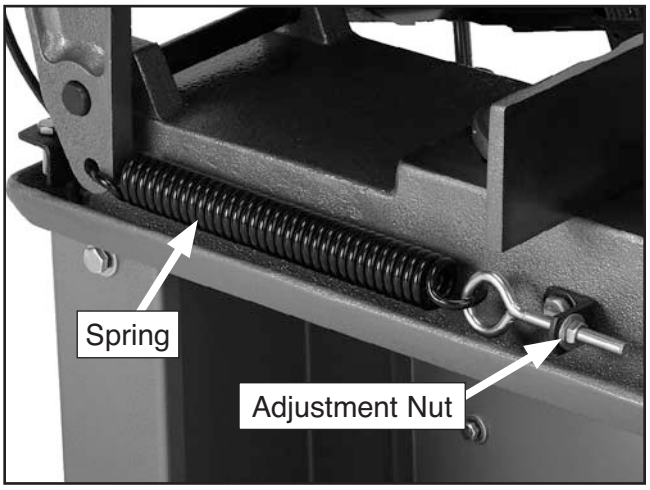


Figure 22. Spring tension adjustment.

3. Clamp the workpiece in the table vise.

4. Close the feed ON/OFF valve to lock the headstock and blade a few inches above the workpiece (see **Figure 23**).

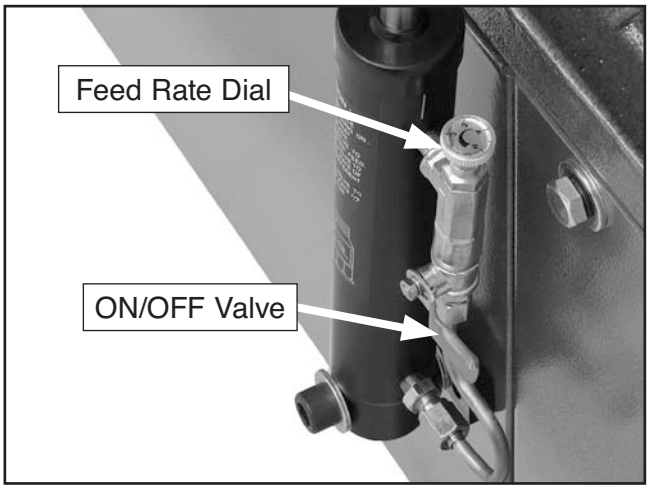


Figure 23. Feed rate dial.

5. With the correct saw blade and blade speed selected, turn the saw and lubricant pump ***ON***.

6. Slowly rotate the feed rate dial clockwise to a slow feed rate until the saw begins to cut the workpiece (see **Figure 23**).

7. Observe the chips that exit the cut, and increase or decrease the feed rate according to the chip characteristics (see **Figure 24**).

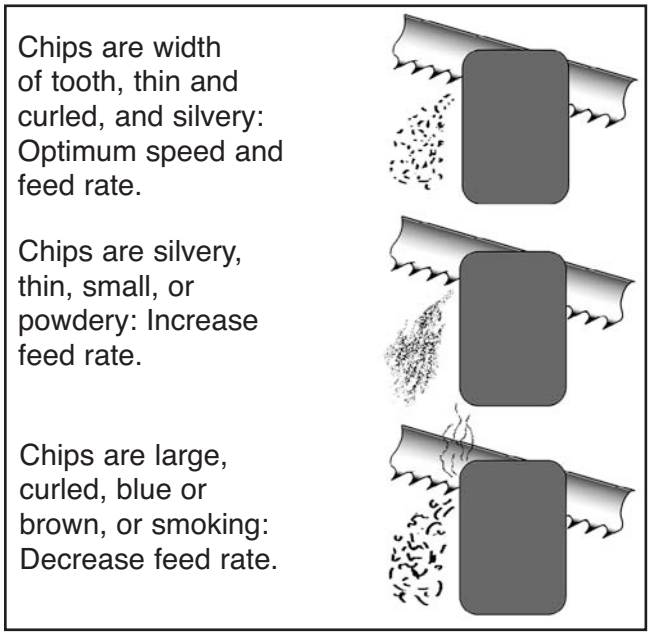

Chips are width of tooth, thin and curled, and silvery: Optimum speed and feed rate.
Chips are silvery, thin, small, or powdery: Increase feed rate.
Chips are large, curled, blue or brown, or smoking: Decrease feed rate.

Figure 24. Reading chip characteristics.

Operation Tips

The following tips will help you safely and effectively operate your bandsaw and help you get the maximum life out of your saw blades.

Tips for horizontal cutting:

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length (see **Figure 25**).
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material.
- Let the blade reach full speed before engaging the workpiece. Never start a cut with the blade in contact with the workpiece (see **Figure 26**).
- Chips should be curled and silvery. If the chips are thin and powder like, increase your feed rate.
- Chips that are burned, indicate a need to reduce your feed rate.
- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!
- Support long pieces so they won't fall when cut and flag the end to alert passers-by of potential danger.

Tips for vertical cutting:

- Make sure that the vertical table assembly is securely fastened to the bandsaw frame so it will adequately support the workpiece.
- Always keep your fingers away from the blade and always hold the workpiece securely in your hand (**Figure 27**).
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.

Figure 25. Using the work stop.

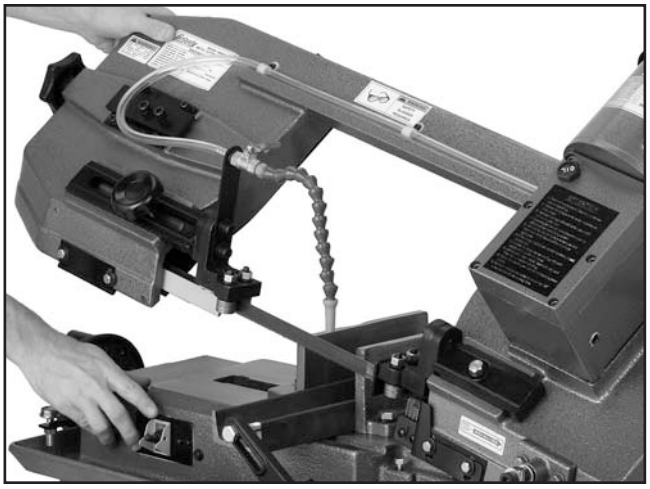


Figure 26. Proper starting position.

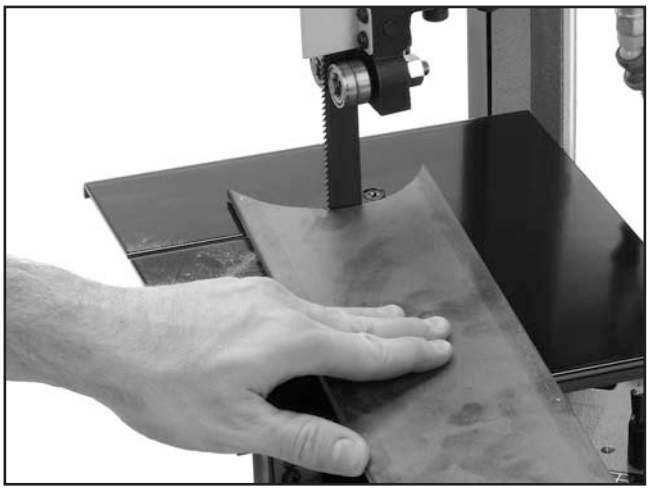


Figure 27. Using the vertical set-up.

SECTION 5: ACCESSORIES

⚠WARNING

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

Call 1-800-523-4777 To Order

G5451—85 x 3/4 x .032 10 TPI Raker
G5452—85 x 3/4 x .032 14 TPI Raker
G5453—85 x 3/4 x .032 18 TPI Raker
G5454—85 x 3/4 x .032 4-6 Variable Pitch
G5455—85 x 3/4 x .032 5-8 Variable Pitch
G5456—85 x 3/4 x .032 6-10 Variable Pitch
G5457—85 x 3/4 x .032 8-12 Variable Pitch
G5458—85 x 3/4 x .032 10-14 Variable Pitch

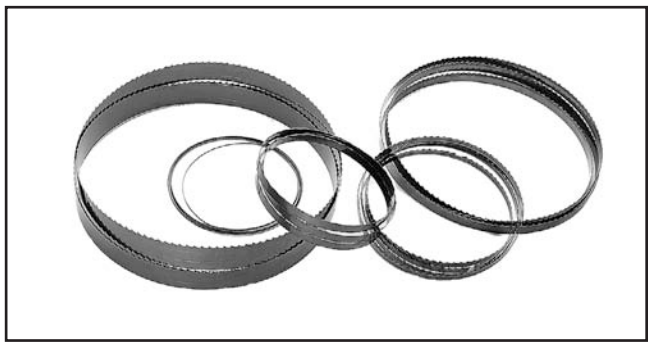


Figure 28. Blades

H5405—Lenox® Lube Tube™
Lenox® Lube Tube™ is a stick lubricant designed to prevent heat buildup. Apply it directly to the blade to improve overall blade life and productivity. Can be used on ferrous and non-ferrous metals. Biodegradeable, non-toxic, and non-staining 14.5 oz. tube.

Figure 29. Lenox® Lube Tube™.

NOTICE

Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 30. Recommended products for protecting unpainted cast iron/steel part on machinery.

H5408—Blade Tensioning Gauge
The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.

Figure 31. H5408 Blade Tensioning Gauge.

G5618—Deburring Tool w/2 Blades
G5619—Extra Aluminum Blade
G5620—Extra Brass and Cast Iron Blade
The quickest tool for smoothing freshly machined metal edges. Comes with two blades, one for steel and aluminum and one for brass and cast iron.

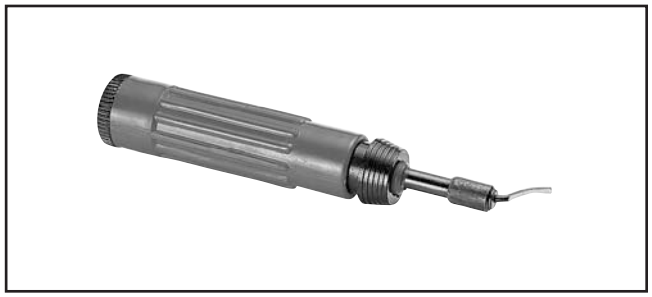


Figure 32. G5618 Deburring tool.

T20501—Face Shield Crown Protector 4"
T20502—Face Shield Crown Protector 7"
T20503—Face Shield Window
T20452—"Kirova" Anti-Reflective S. Glasses
T20451—"Kirova" Clear Safety Glasses
H0736—Shop Fox® Safety Glasses
H7194—Bifocal Safety Glasses 1.5
H7195—Bifocal Safety Glasses 2.0
H7196—Bifocal Safety Glasses 2.5

Figure 33. Eye protection assortment.

H4978—Deluxe Earmuffs - 27dB
H4979—Twin Cup Hearing Protector - 29dB
T20446—Ear Plugs 200 Pair - 31dB
Protect your hearing before its too late. Especially important if you or employees operate for hours at a time.

Figure 34. Hearing protection assortment.

G9256—6" Dial Caliper
G9257—8" Dial Caliper
G9258—12" Dial Caliper
These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display.

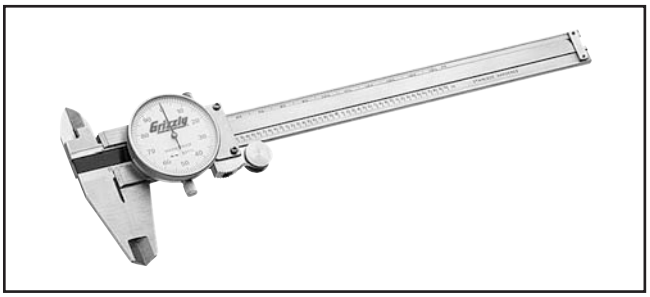
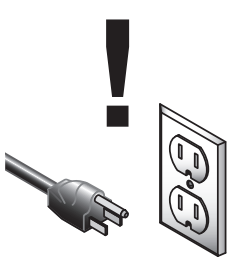


Figure 35. Grizzly® Dial Calipers.

Call 1-800-523-4777 To Order

SECTION 6: MAINTENANCE



⚠WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:
- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.
- Clean after each use.

Monthly Check:
- Lubricate vise screw.
- Check gear box fluid level.

Annual Check:
- Change gear box oil (Every three months if being used daily).

Cleaning

Cleaning the Model G4030 is relatively easy. After using your bandsaw, remove excess chips by sweeping and remove any excess coolant with a dry towel.

Lubrication

Before applying lubricant to any area, wipe the area clean to avoid contamination. Lubricate the vice screw shown in **Figure 36** with general purpose grease.

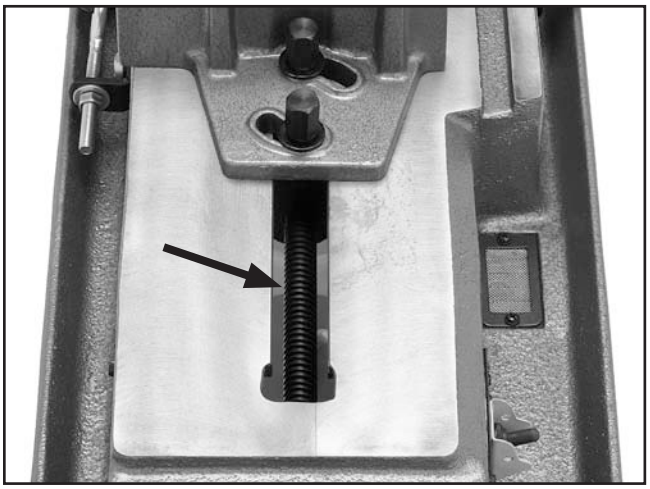


Figure 36. Vise screw lubrication area.

Change gear box oil by removing the drain plug on the right side or the gear box (out of view) in **Figure 37** and drain the gearbox. Replace the drain plug and refill through the fill cap with 90W automotive gear oil.

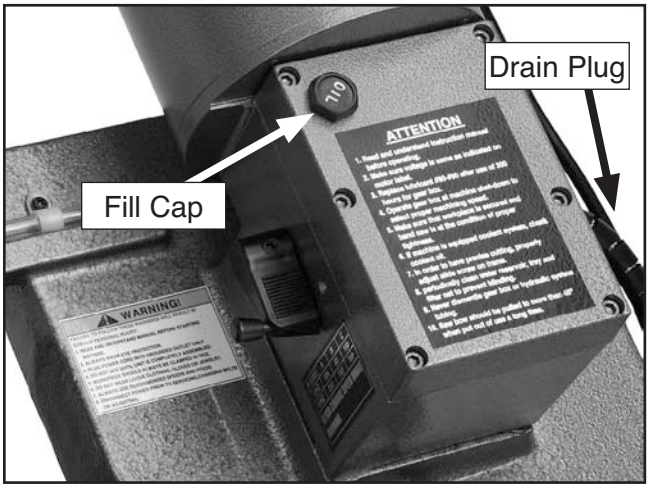
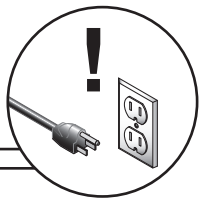


Figure 37. Gear box lubrication.

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Plug/receptacle is at fault or wired incorrectly. 2. Start capacitor is at fault. 3. Wall fuse/circuit breaker is blown/tripped. 4. Motor connection wired incorrectly. 5. Power supply is at fault/switched OFF. 6. Motor ON/OFF switch is at fault. 7. Wiring is open/has high resistance. 8. Motor is at fault.	1. Test for good contacts; correct the wiring. 2. Test/replace if faulty. 3. Ensure correct size for machine load; replace weak breaker. 4. Correct motor wiring connections. 5. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 6. Replace faulty ON/OFF switch. 7. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 8. Test/repair/replace.
Machine stalls or is underpowered.	1. Wrong blade for the workpiece material. 2. Wrong workpiece material. 3. Feed rate/cutting speed too fast for task. 4. Blade is slipping on wheels. 5. Low power supply voltage. 6. Motor bearings are at fault. 7. Plug/receptacle is at fault. 8. Motor connection is wired incorrectly. 9. Plug/receptacle is at fault. 10.Motor has overheated. 11.Motor is at fault.	1. Use blade with correct properties for your type of cutting. 2. Use metal with correct properties for your type of cutting. 3. Decrease feed rate/cutting speed. 4. Adjust blade tracking and tension. 5. Ensure hot lines have correct voltage on all legs. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 7. Test for good contacts; correct the wiring. 8. Correct motor wiring connections. 9. Test for good contacts; correct the wiring. 10.Clean off motor, let cool, and reduce workload. 11.Test/repair/replace.
Machine has vibration or noisy operation.	1. Motor fan is rubbing on fan cover. 2. Blade is at fault. 3. Gearbox is at fault.	1. Replace dented fan cover; replace loose/damaged fan. 2. Replace/resharpen blade. 3. Rebuild gearbox for bad gear(s)/bearing(s).

Bandsaw Operations

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine is loud when cutting or bogs down in the cut.	1. Excessive feed rate. 2. The blade TPI is too great, or the material is too coarse.	1. Refer to **Feed Rate** on **Page 22**, or **Changing Blade Speed** on **Page 19**, and adjust as required. 2. Refer to **Blade Selection** on **Page 20** and adjust as required.
Blades break often.	1. Blade is not tensioned correctly. 2. The workpiece is loose in the vise. 3. The feed or cut speed is wrong. 4. The blade TPI is too great, or the material is too coarse. 5. The blade is rubbing on the wheel flange. 6. The bandsaw is being started with the blade resting on the workpiece. 7. The guide bearings are misaligned, or the blade is rubbing on the wheel flange. 8. The blade is too thick, or the blades are of low quality.	1. Check to see that blade is not excessively tight or too loose. 2. Clamp the workpiece tighter, or use a jig to hold the workpiece. 3. Refer to **Feed Rate** on **Page 22**, or **Changing Blade Speed** on **Page 19**, and adjust as required. 4. Refer to **Blade Selection** on **Page 20**, and adjust as required. 5. Refer to **Blade Tracking** on **Page 30**, and adjust as required. 6. Start bandsaw and then slowly lower the headstock by setting the feed rate. 7. Refer to **Blade Tracking** on **Page 30**, or **Blade Guides** on **Page 21**, and adjust as required. 8. Use a higher quality blade.
Blade dulls prematurely.	1. The cutting speed is too fast. 2. The blade TPI is too coarse. 3. The blade feed pressure is too light. 4. The workpiece has hard spots, welds, or scale is on the material. 5. The blade is twisted. 6. The blade is slipping on the wheels.	1. Refer to **Changing Blade Speed** on **Page 19**, and adjust as required. 2. Refer to **Blade Selection** on **Page 20**, and adjust as required. 3. Refer to **Feed Rate** on **Page 22**, and adjust as required. 4. Increase the feed pressure, and reduce the cutting speed. 5. Replace the blade. 6. Refer to **Blade Tension** on **Page 31**, and adjust as required.
Blade wears on one side.	1. The blade guides are worn or mis-adjusted. 2. The blade guide slide bracket is loose. 3. The wheels are out of alignment.	1. Refer to **Blade Guides** on **Page 21** and replace or adjust. 2. Tighten the blade guide bracket. 3. Refer to **Blade Tracking** on **Page 30**, and adjust as required.
Teeth are ripping from the blade.	1. The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece. 2. The workpiece is vibrating in the vise. 3. The blade gullets are loading up with chips.	1. Refer to **Blade Selection** on **Page 20** and decrease the feed pressure. Refer to **Feed Rate** on **Page 22**, and adjust as required. 2. Re-clamp the workpiece in the vise, and use a jig if required. 3. Use a coarser-tooth blade.
The cuts are crooked.	1. The feed pressure is too high. 2. The guide bearings are out of adjustment, or too far away from the workpiece. 3. The blade tension is low. 4. The blade is dull. 5. The blade speed is wrong.	1. Refer to **Feed Rate** on **Page 22**, and adjust as required. 2. Refer to **Blade Guides** on **Page 21** and replace or adjust. 3. Refer to **Blade Tension** on **Page 31**, and adjust as required. 4. Refer to **Changing the Blade** on **Page 29** and replace the blade. 5. Refer to **Changing Blade Speed** on **Page 19**, and adjust as required.

Blade Change

Blades should be changed when they become dull, damaged, or when you are using materials that require a blade with a certain type or tooth count.

To change the blade on the bandsaw:

1. UNPLUG THE BANDSAW!

2. Raise the head of the bandsaw to the vertical position, close the Feed ON/OFF valve, and remove the wheel access cover.

3. Remove the blade guard.

4. Loosen the tension knob in **Figure 38** and slip the blade off of the wheels. This knob will be very tight and may be hard to loosen.

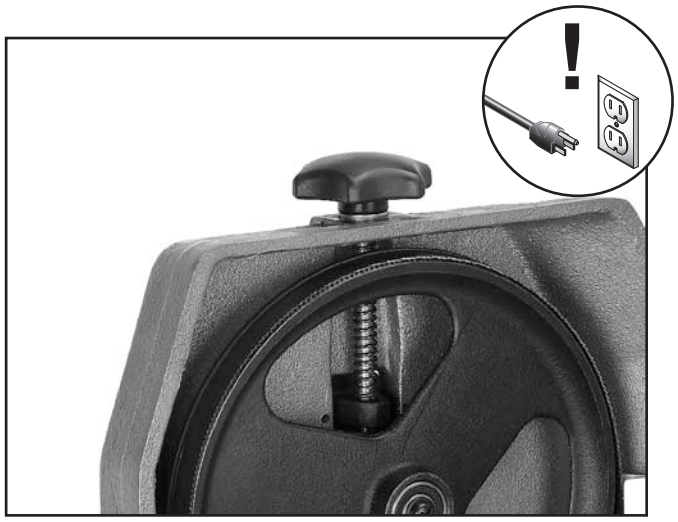


Figure 38. Tension knob and blade.

4. Install the new blade through both blade guide bearings, as shown in **Figure 39,** and around the bottom wheel.

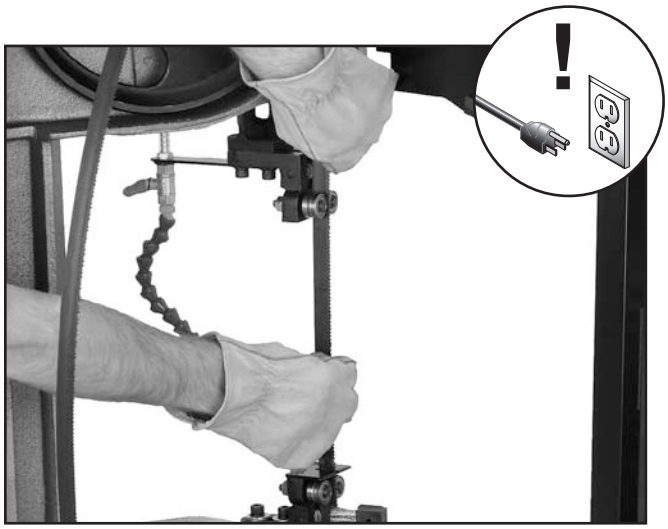


Figure 39. Installing blade.

5. Hold the blade around the bottom wheel with one hand and slip it around the top wheel with the other hand, keeping the blade between the blade guide bearings.

   Note: *It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth are facing toward the workpiece, as shown in* ***Figure 40****, after mounting to the bandsaw. Some blades will have a directional arrow as a guide.*

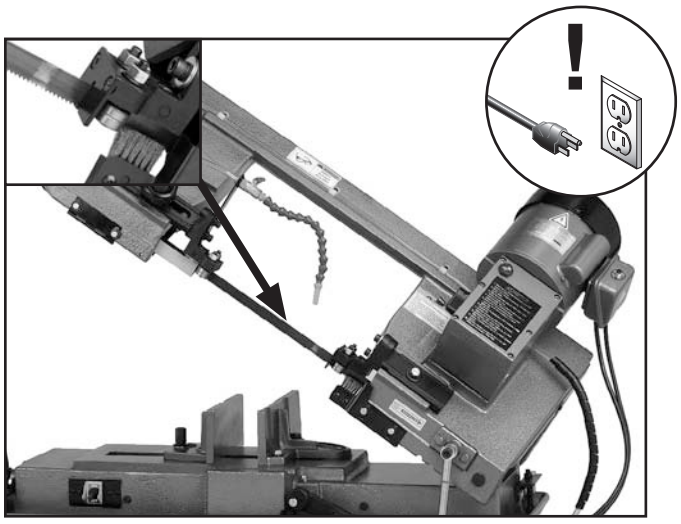


Figure 40. Blade cutting direction.

6. When the blade is around both wheels, adjust the position so the back of the blade is against the shoulder of the wheels.

7. Tighten the tension knob as tight as necessary so the blade will not slip on the wheels on start up.

8. Put the gearbox in neutral by moving the gear change lever between two of the speed positions.

9. Spin the wheel by hand until the blade resumes the previous tracking.

10 Put the gearbox back in gear.

   —If the tracking needs to be adjusted, refer to the **Tracking** procedure in the next section.

   —If the tracking is fine, proceed to **Blade Tension** on **Page 31**.

Blade Tracking

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly.

To adjust the blade tracking on the bandsaw:

1. UNPLUG THE BANDSAW!

2. Position the bandsaw in the vertical position and close the feed rate ON/OFF valve.

3. Open the wheel access cover.

4. Loosen, but do not remove the lower cap screw in the blade wheel tilting mechanism (**Figure 41**).

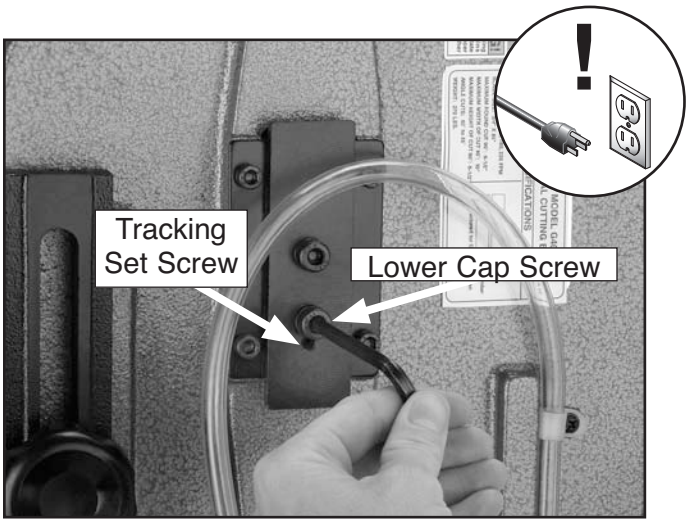


Figure 41. Adjusting tracking set screw.

5. Relax the blade tension.

6. Adjust the tracking set screw with a 4mm hex wrench as shown in **Figure 41**, then tighten the cap screw loosened in **Step 4**.

   —Tightening the set screw will move the blade closer to the shoulder of the wheel.

   —Loosening the set screw will move the blade away from the shoulder.

7. Tension the blade.

8. Put the gearbox in neutral by moving the gear change lever between two of the speed positions and spin the wheel by hand.

   —If the blade tracks along the shoulder of the wheel (without rubbing), the blade is tracking properly and this adjustment is completed.

   —If the blade drifts away from the shoulder of the wheel or hits the shoulder, repeat **Steps 4-7**.

9. Replace the blade guard and wheel access cover.

Blade Tension

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting times.

Two major signs that you do not have proper blade tension are: 1) the blade stalls in the cut and slips on the wheels, and 2) the blade frequently breaks from being too tight.

To tension the blade on the bandsaw:

1. Make sure the blade is tracking properly.

2. UNPLUG THE BANDSAW!

3. Loosen and slide the blade guides as far apart as they will go, then tighten them down again.

4. Turn the tension knob in **Figure 42** clockwise to tighten the blade.

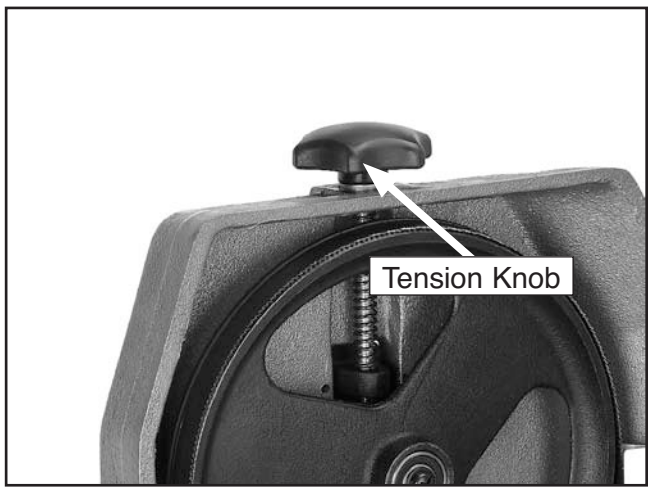


Figure 42. Tension knob and blade.

5. Using moderate finger pressure, push against the side of the blade. The blade should not move more than 0.040"–0.050" (1.0mm-1.2mm). This is an adjustment done by feel and experience more than anything. You want to find that fine line between the blade slipping off the wheel and breaking blades from too much tension.

6. Another option is to use a blade tensioning gauge, like the one found in **SECTION 5: ACCESSORIES** on **Page 24**. Please follow the instructions included with your gauge.

Squaring the Blade

It is always a good idea during the life of your saw to check and adjust this setting. This adjustment will improve your cutting results and extend the life of your blade.

To square the blade to the bed of the table:

1. UNPLUG THE BANDSAW!

2. Lower the head of the bandsaw all the way until it contacts the horizontal stop.

3. Place a square on the table bed and against the edge of the blade (**Figure 43**), and check different points along the length of the table between the blade guides.

4. Loosen the cap screws shown in **Figure 43**, and rotate the blade guide until the blade is vertical to the bed, then tighten the cap screws.

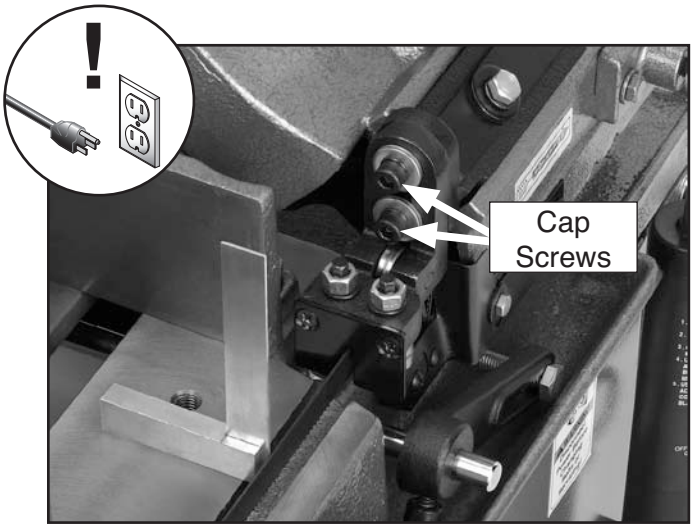


Figure 43. Squaring the blade.

Blade Guide Bearings

The blade guide bearings come adjusted from the factory and the need for adjustment should rarely occur. Uneven blade wear and crooked cuts may be the result of improper adjustment. Each bearing assembly has an eccentric bushing that allows the distance between the blade and bearings to be adjusted. The bearings are secured in place by a hex nut and a lock washer as shown in **Figure 44.**

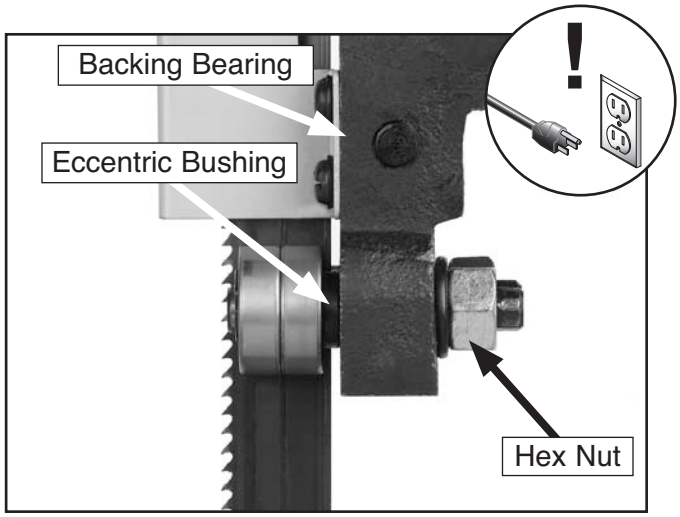


Figure 44. Blade guide adjustments.

To adjust the blade guide bearings:

1. UNPLUG THE BANDSAW!

2. Position the bandsaw in the vertical position and close the feed rate ON/OFF valve.

3. Using a 12mm open-end wrench, loosen the hex nut that secures the bearing to the eccentric bushing.

4. Using a 7mm open-end wrench, adjust the eccentric bushing position to achieve the desired clearance. The bearing and blade should make light contact or have a clearance of 0.001"-0.002"

5. Tighten the nut to lock the bearing in position.

6. Adjust the other eccentric blade guide bearing in the same manner. The backing bearing is not adjustable and will make contact with the blade.

Electrical Components

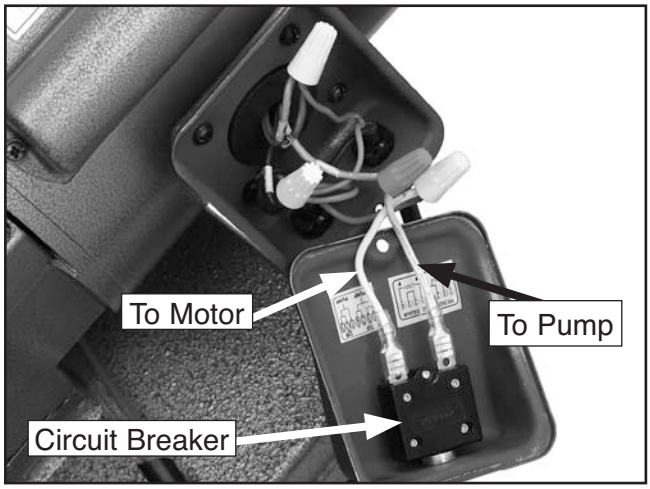


Figure 45. Motor wiring inside junction box.

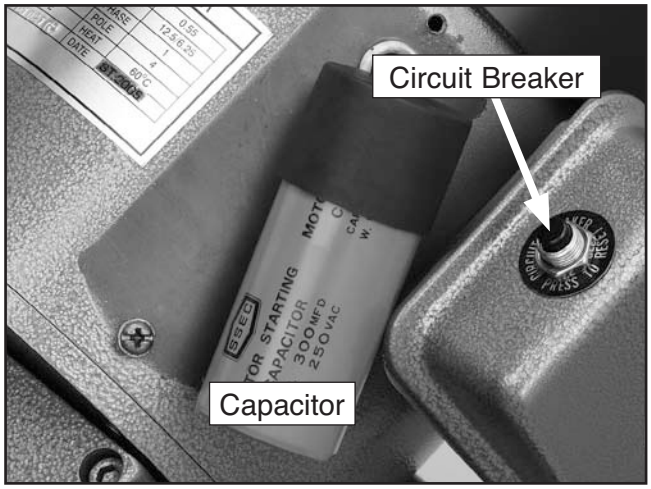


Figure 48. G4030 Start capacitor.

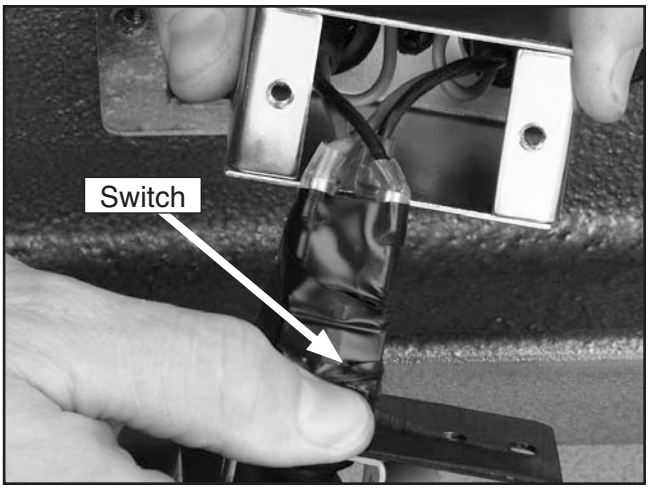


Figure 46. Bandsaw ON/OFF Switch wiring.

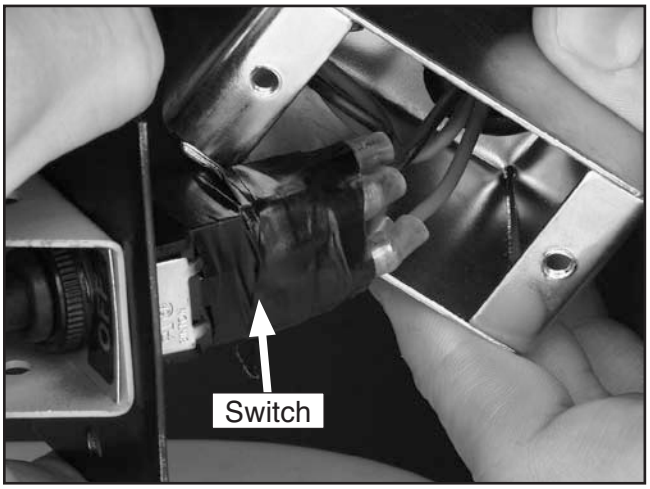
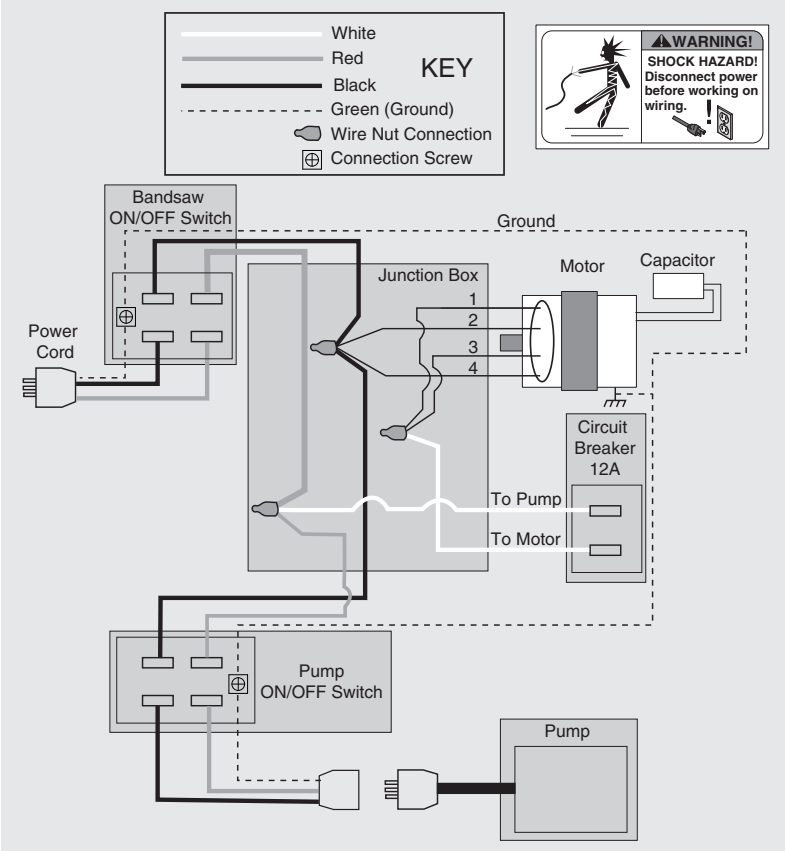


Figure 49. Pump ON/OFF Switch wiring.

Figure 47. Submersible pump.

Wiring Diagram G4030

110 Volt



220 Volt

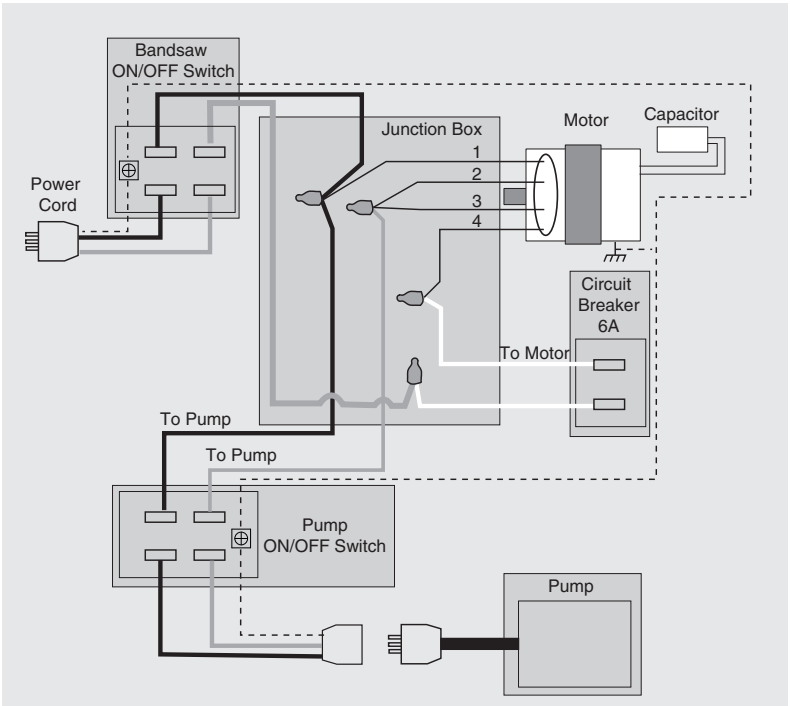
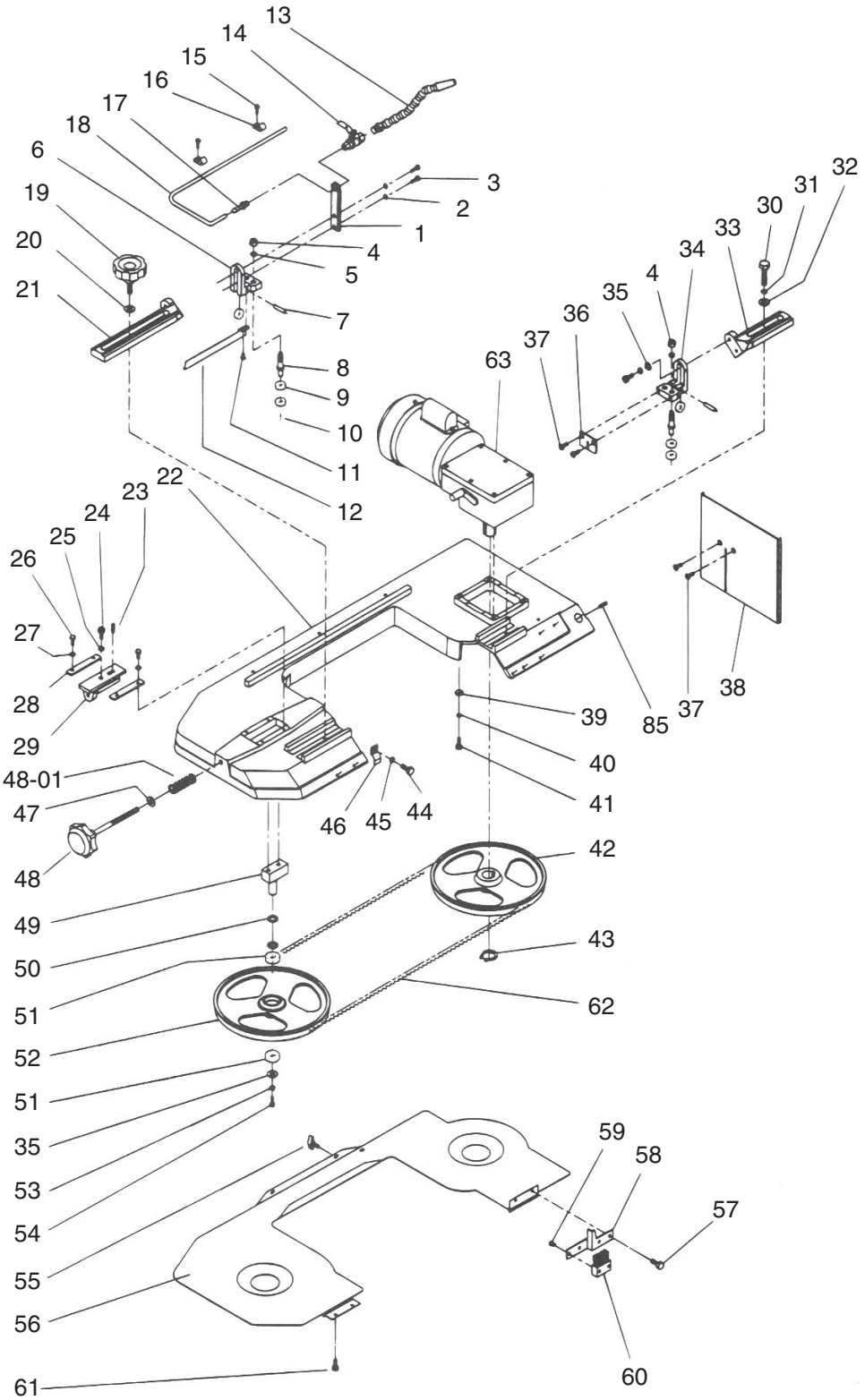
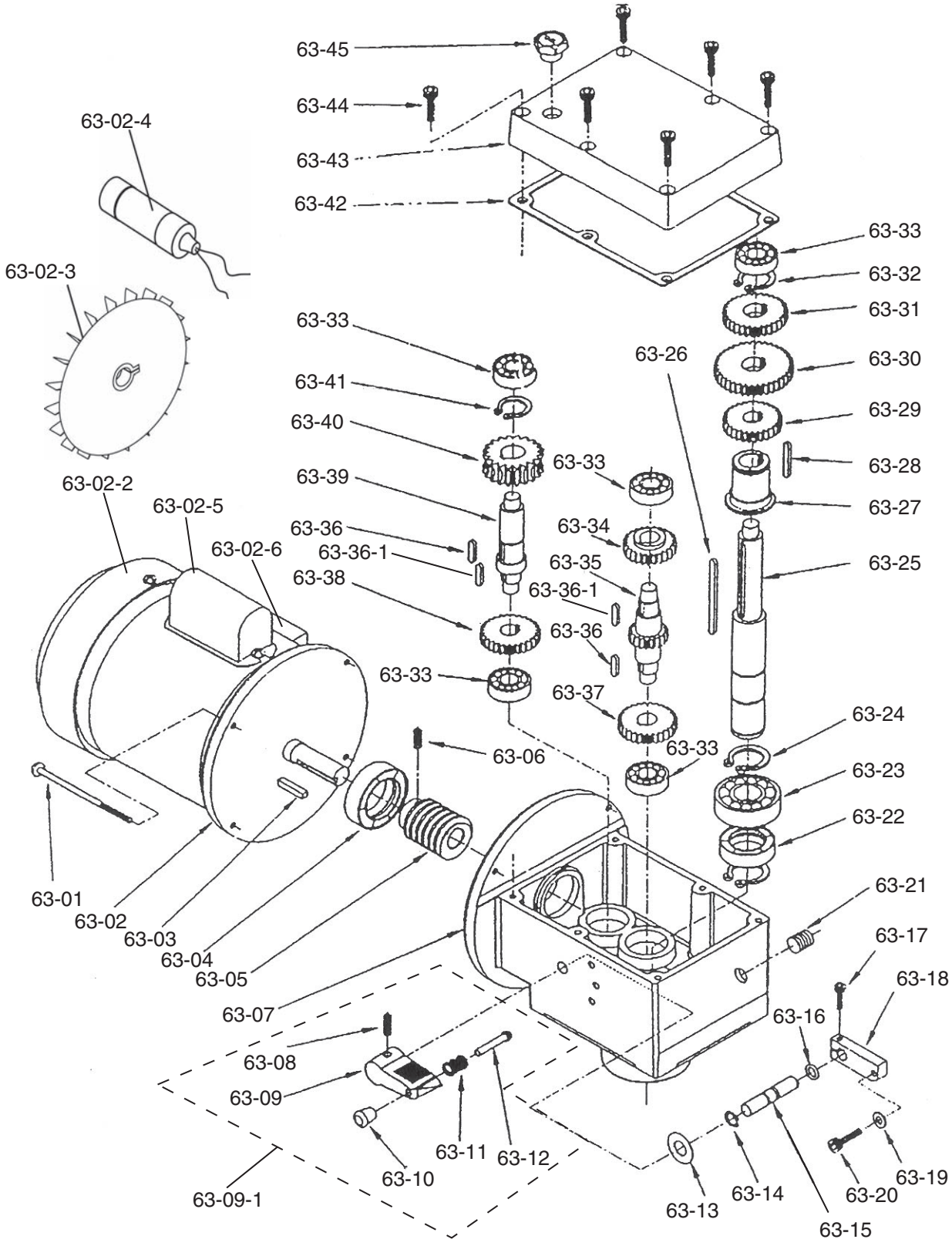


Figure 50. G4030 Wiring Diagrams.

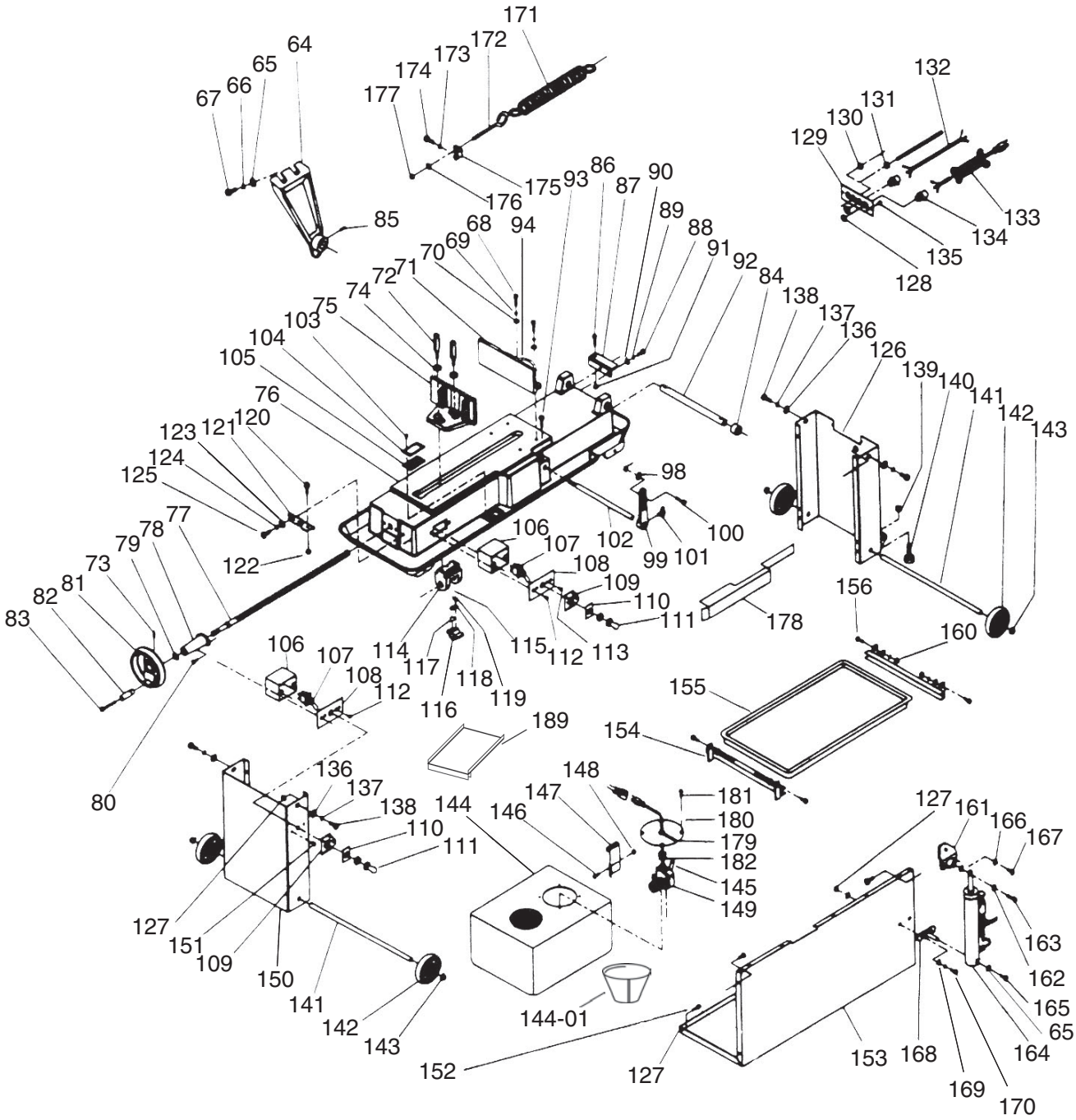
Parts Breakdown G4030



Parts Breakdown G4030



Parts Breakdown G4030



Parts List G4030

REF	PART #	DESCRIPTION
1	P4030001	VALVE COCK SUPPORT
2	PLW01	LOCK WASHER 5/16
3	PSS21M	SET SCREW M8-1.25 X 25
4	PN08	HEX NUT 3/8-16
5	PLW04	LOCK WASHER 3/8
6	P4030006	BLADE ADJUSTER (FRONT)
7	P4030007	PIN
8	P4030008	ECCENTRIC SHAFT
9	P608	BALL BEARING 608ZZ
10	PR36M	EXT RETAINING RING 7MM
11	PSB03M	CAP SCREW M5-.8 X 8
12	P4030012	BLADE COVER (FRONT)
13	P4030013	WATER NOZZLE
14	P4030014	VALVE 1/4
15	PS06	PHLP HD SCR 10-24 X 3/8
16	P4030016	HOSE BUTTON
17	P4030017	HOSE PLUG 1/4
18	P4030018	HOSE
19	P4030019	ADJUSTING KNOB 3/8
20	PW02	FLAT WASHER 3/8
21	P4030021	ADJUSTABLE BRACKET (FRONT)
22	P4030022	HEADSTOCK
23	PSS06M	SET SCREW M8-1.25 X 16
24	PB15M	HEX BOLT M8-1.25 X 40
25	PLW04M	LOCK WASHER 8MM
26	PB15M	HEX BOLT M8-1.25 X 40
27	PW03M	FLAT WASHER 6MM
28	P4030028	SLIDE
29	P4030029	BLADE TENSION SLIDING BLOCK
30	PB16	HEX BOLT 3/8-16 X 1 1/2
31	PLW06M	LOCK WASHER 10MM
32	PW02	FLAT WASHER 3/8
33	P4030033	ADJUSTABLE BRACKET (REAR)
34	P4030034	BLADE ADJUSTER (REAR)
35	PW01M	FLAT WASHER 8MM
36	P4030036	DEFLECTOR PLATE
37	PFH03	FLAT HD SCR 1/4-20 X 1/2
38	P4030038	TABLE
39	PW01M	FLAT WASHER 8MM
40	PLW04M	LOCK WASHER 8MM
41	PB07M	HEX BOLT M8-1.25 X 25
42	P4030042	BLADE WHEEL (REAR)
43	PR58M	EXT RETAINING RING 24MM
44	PB17M	HEX BOLT M8-1.25 X 10
45	PW06	FLAT WASHER 1/4
46	P4030046	SWITCH HIP
47	PW02	FLAT WASHER 3/8
48	P4030048	BLADE TENSION KNOB
48-01	P4030048-01	SPRING 1.8 X 14 X 102
49	P4030049	BLADE WHEEL SHAFT (FRONT)
50	P4030050	INTERVAL RING
51	P6202	BALL BEARING 6202ZZ
52	P4030052	BLADE WHEEL (FRONT)
53	PLW04M	LOCK WASHER 8MM
54	PB87M	HEX BOLT M8-1.25 X 15
55	P4030055	ADJUSTING KNOB 1/4
56	P4030056	BLADE BACK COVER
57	PSB04	CAP SCREW 1/4-20 X 1/2
58	P4030058	BRUSH HOLDER
59	PHTEK23	TAP SCREW #10 X 1/2
60	P4030060	BRUSH
61	PB19	HEX BOLT 1/4-20 X 1/2
62	P4030062	BLADE
63	P4030063	COMPLETE GEAR BOX W/ MOTOR
63-01	P4030063-01	PAN HD SCREW M5-.8 X 145
63-02	P4030063-02	MOTOR WITHOUT GEAR BOX
63-02-2	P4030063-02-2	MOTOR FAN COVER
63-02-3	P4030063-02-3	FAN
63-02-4	P4030063-02-4	CAPACITOR 300MFD 250VAC
63-02-5	P4030063-02-5	CAPACITOR COVER
63-02-6	P4030063-02-6	JUNCTION BOX
63-03	PK53M	KEY 3 X 3 X 45
63-04	P4030063-04	OIL SEAL
63-05	P4030063-05	WORM SHAFT
63-06	PSS02M	SET SCREW M6-1 X 6
63-07	P4030063-07	GEAR BOX
63-08	PSS20M	SET SCREW M8-1.25 X 8
63-09	P4030063-09	HANDLE
63-09-1	P4030063-09-1	COMPLETE HANDLE ASSY
63-10	P4030063-10	VARIABLE SPEED PIN HEAD
63-11	P4030063-11	SPRING N/S .8 X .5 X 25
63-12	P4030063-12	VARIABLE SPEED PIN
63-13	PW04M	FLAT WASHER 10MM
63-14	PR01M	EXT RETAINING RING 10MM
63-15	P4030063-15	VARIABLE SPEED SHAFT
63-16	P4030063-16	O-RING
63-17	P4030063-17	SWING LEVER BOLT
63-18	P4030063-18	SWING LEVER
63-19	PW03M	FLAT WASHER 6MM
63-20	P4030063-20	SWING LEVER BOLT
63-21	P4030063-21	OIL PLUG
63-22	P4030063-22	OIL SEAL
63-23	P6205	BALL BEARING 6205ZZ
63-24	P4030063-24	SHAFT LOCK RING
63-25	P4030063-25	MAIN SHAFT
63-26	P4030063-26	SHAFT KEY
63-27	P4030063-27	BUSHING
63-28	PK38M	KEY 4 X 4 X 22
63-29	P4030063-29	#1 GEAR
63-30	P4030063-30	#2 GEAR

Parts List G4030

REF	PART #	DESCRIPTION
63-31	P4030063-31	#3 GEAR
63-32	PR17M	EXT RETAINING RING 26MM
63-33	P6201	BALL BEARING 6201
63-34	P4030063-34	SECOND SHAFT GEAR
63-35	P4030063-35	SECOND SHAFT
63-36	PK10M	KEY 5 X 5 X 12
63-36-1	PK06M	KEY 5 X 5 X 10
63-37	P4030063-37	GEAR
63-38	P4030063-38	GEAR
63-39	P4030063-39	COUNTER SHAFT
63-40	P4030063-40	WORM GEAR
63-41	PR07M	EXT RETAINING RING 18MM
63-42	P4030063-42	GASKET SHEET
63-43	P4030063-07	GEAR BOX
63-44	P4030063-44	HEX COUNTERSUNK SCREW
63-45	P4030063-45	OIL PLUG
64	P4030064	PIVOT BRACKET
65	PW06M	FLAT WASHER 12MM
66	PLW05M	LOCK WASHER 12MM
67	PB35M	HEX BOLT M12-1.75 X 40
68	PB35M	HEX BOLT M12-1.75 X 40
69	PLW05M	LOCK WASHER 12MM
70	PW06M	FLAT WASHER 12MM
71	P4030071	FIXED VISE
72	PB73M	HEX BOLT M10-1.5 X 50
73	PSS20M	SET SCREW M8-1.25 X 8
74	PW06M	FLAT WASHER 12MM
75	P4030075	FREE VISE
76	P4030076	TABLE
77	P4030077	ACME SCREW
78	P4030078	SCREW SERVILE
79	PR02M	EXT RETAINING RING 14MM
80	PSS12M	SET SCREW M6-1 X 25
81	P4030081	HANDWHEEL
82	P1026101	HANDWHEEL HANDLE
83	P1026101	HANDLE BOLT
84	P4030084	BUSHING
85	PSS06M	SET SCREW M8-1.25 X 16
86	PSB26	CAP SCREW 3/8-16 X 1 1/2
87	P4030087	SUPPORT PLATE
88	PB07M	HEX BOLT M8-1.25 X 25
89	PLW04M	LOCK WASHER 8MM
90	PW04M	FLAT WASHER 10MM
91	PN08	HEX NUT 3/8-16
92	P4030092	SUPPORT ROD
93	PB87M	HEX BOLT M8-1.25 X 15
94	P4030094	SCALE
98	PN02M	HEX NUT M10-1.5
99	P4030099	LENGTH FIXING PLATE
100	PSB47M	CAP SCREW M10-1.5 X 40

REF	PART #	DESCRIPTION
101	P4030101	FIXED BOLT
102	P4030102	STOCK STOP ROD
103	PS06	PHLP HD SCR 10-24 X 3/8
104	P4030104	FILTER NET PLATE
105	P4030105	FILTER NET
106	P4030106	SWITCH COVER
107	P0561057	TOGGLE SWITCH ASSEMBLY
108	P4030108	SWITCH COVER PLATE
109	P4030109	SWITCH COVER
110	P4030110	SWITCH BRAND
111	P0561071	TOGGLE SWITCH COVER
112	PS06	PHLP HD SCR 10-24 X 3/8
113	PS06	PHLP HD SCR 10-24 X 3/8
114	P4030114	BRACKET
115	PRP07M	ROLL PIN 6 X 20
116	P4030116	STOP COLLAR (ACME NUT)
117	P4030117	STEEL BALL
118	P4030118	SHELL FRAGMENT
119	PS05M	PHLP HD SCR M5-.8 x 8
120	P4030120	BOLT
121	P4030121	SUPPORT
122	PN08	HEX NUT 3/8-16
123	PW01M	FLAT WASHER 8MM
124	PLW04M	LOCK WASHER 8MM
125	PB07M	HEX BOLT M8-1.25 X 25
126	P4030126	REAR STAND PLATE
127	PN01M	HEX NUT M6-1
128	P4030128	STRAIN RELIEF
129	P4030129	WIRE PLATE
130	P4030130	PLUG
131	P4030131	WIRE PLUG
132	P4030132	MOTOR WIRE
133	P4030132	MOTOR WIRE
134	P4030134	STRAIN RELIEF
135	PS06	PHLP HD SCR 10-24 X 3/8
136	PW04M	FLAT WASHER 10MM
137	PLW06M	LOCK WASHER 10MM
138	PSB64M	CAP SCREW M10-1.5 X 25
139	PN06	HEX NUT 1/2-12
140	PB20	HEX BOLT 1/2-12 X 2 1/2
141	P4030141	WHEEL SHAFT
142	P4030142	WHEEL
143	P4030143	WHEEL BUTTON
144	P4030144	COOLANT TANK
144-01	P4030144-01	COOLANT TANK FILTER
145	P4030145	DRAIN PLUG
146	PS06	PHLP HD SCR 10-24 X 3/8
147	P4030147	PUMP MOUNT
148	PN07	HEX NUT 10-24
149	P4030149	COOLING PUMP

Parts List G4030

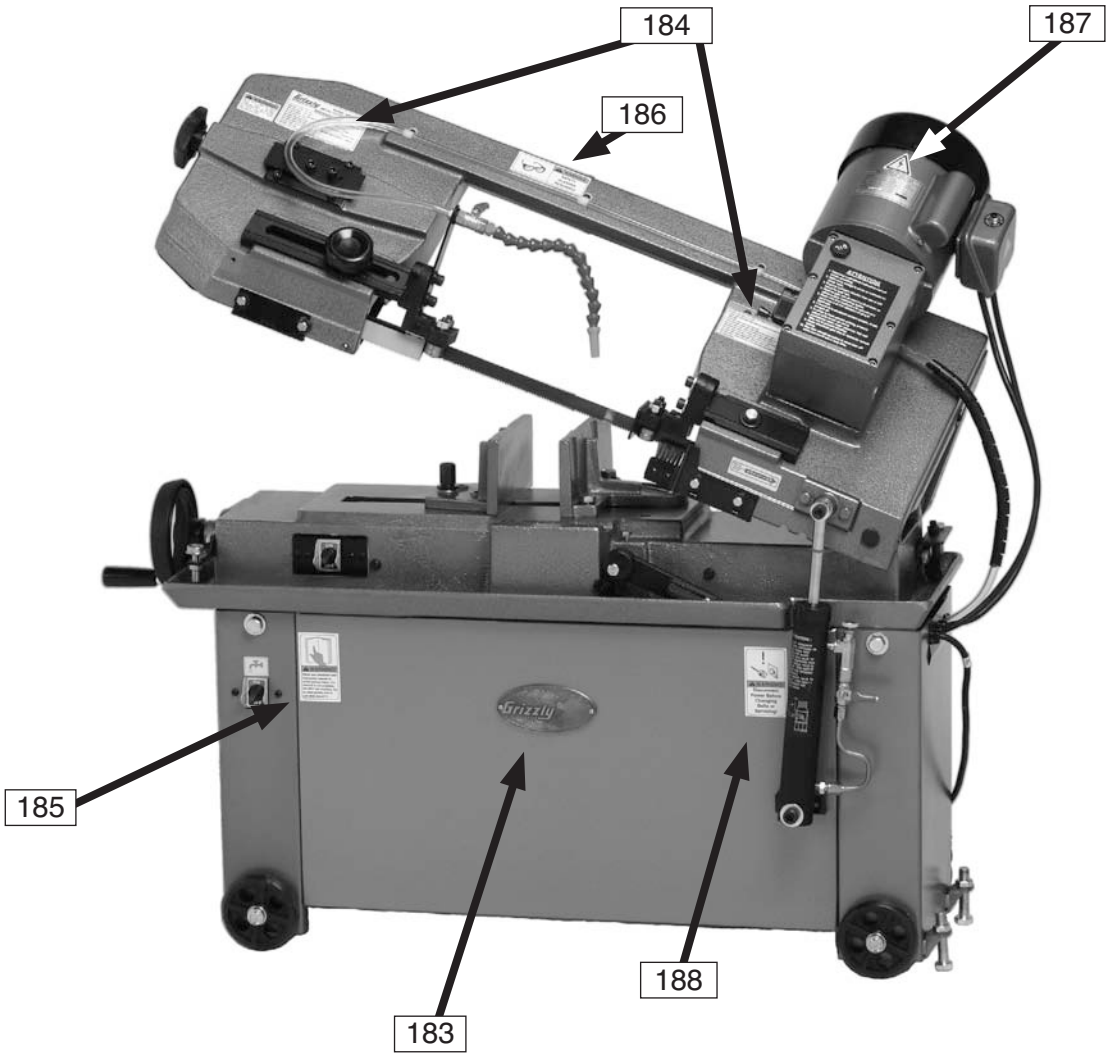
REF	PART #	DESCRIPTION
150	P4030150	FRONT STAND PLATE
151	PS06	PHLP HD SCR 10-24 X 3/8
152	PB04M	HEX BOLT M6-1 X 10
153	P4030153	SIDE STAND PLATE
154	P4030154	WATER TROUGH SHELF
155	P4030155	DRIP PAN
156	PB29M	HEX BOLT M6-1 X 30
160	PN01M	HEX NUT M6-1
161	P4030161	CYLINDER SUPPORT- TOP
162	PW04M	FLAT WASHER 10MM
163	PB73M	HEX BOLT M10-1.5 X 50
164	P4030164	CYLINDER
165	PSB63M	CAP SCREW M12-1.75 X 60
166	PW01M	FLAT WASHER 8MM
167	PB09M	HEX BOLT M8-1.25 X 20
168	P4030168	CYLINDER SUPPORT-BOTTOM
169	PW01M	FLAT WASHER 8MM
170	PB03M	HEX BOLT M8-1.25 X 16
171	P4030171	EXTENSION SPRING

REF	PART #	DESCRIPTION
172	P4030172	SPRING ADJUSTABLE ROD
173	PLW06M	LOCK WASHER 10MM
174	PSB64M	CAP SCREW M10-1.5 X 25
175	P4030175	SPRING HANDLE BRACKET
176	PW04M	FLAT WASHER 10MM
177	PN08	HEX NUT 3/8-16
178	P4030178	WATER BAFFLE
179	P4030179	COVER
180	PW06	FLAT WASHER 1/4
181	PFH03	FLAT HD SCR 1/4-20 X 1/2
182	P4030182	STRAIN RELIEF
183	G8588	GRIZZLY NAMEPLATE- SMALL
184	P4030184	MACHINE ID LABEL
185	PLABEL-12	READ MANUAL 2"W X 3 5/16"
186	P4030186	SAFETY GLASSES LABEL
187	PLABEL-14	ELECTRICITY LABEL
188	PLABEL-18	UNPLUG BANDSAW LABEL
189	P4030189	CHIP TRAY

Safety Label Placement

⚠WARNING

The safety labels on this machine warn and indicate how to protect the operator or bystander from machine hazards. The machine owner MUST maintain the original label location and readability. If a label is removed or becomes unreadable, REPLACE the label before using the machine. For new labels, contact Grizzly Industrial Inc. at (570) 546-9663 or techsupport@grizzly.com.



WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____ Invoice # _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement	____ Friend	____ Catalog
____ Card Deck	____ Website	____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinet Maker	____ Popular Mechanics	____ Today's Homeowner
____ Family Handyman	____ Popular Science	____ Wood
____ Hand Loader	____ Popular Woodworking	____ Wooden Boat
____ Handy	____ Practical Homeowner	____ Woodshop News
____ Home Shop Machinist	____ Precision Shooter	____ Woodsmith
____ Journal of Light Cont.	____ Projects in Metal	____ Woodwork
____ Live Steam	____ RC Modeler	____ Woodworker West
____ Model Airplane News	____ Rifle	____ Woodworker's Journal
____ Modeltec	____ Shop Notes	____ Other:
____ Old House Journal	____ Shotgun News	

3. What is your annual household income?

____ $20,000-$29,000	____ $30,000-$39,000	____ $40,000-$49,000
____ $50,000-$59,000	____ $60,000-$69,000	____ $70,000+

4. What is your age group?

____ 20-29	____ 30-39	____ 40-49
____ 50-59	____ 60-69	____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend? _____ Yes _____ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____ Yes _____ No

10. Comments: _____

_____

_____

_____

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Here

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P.O. BOX 2069
BELLINGHAM, WA 98227-2069

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Name_____

Street_____

City_____State_____Zip_____

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